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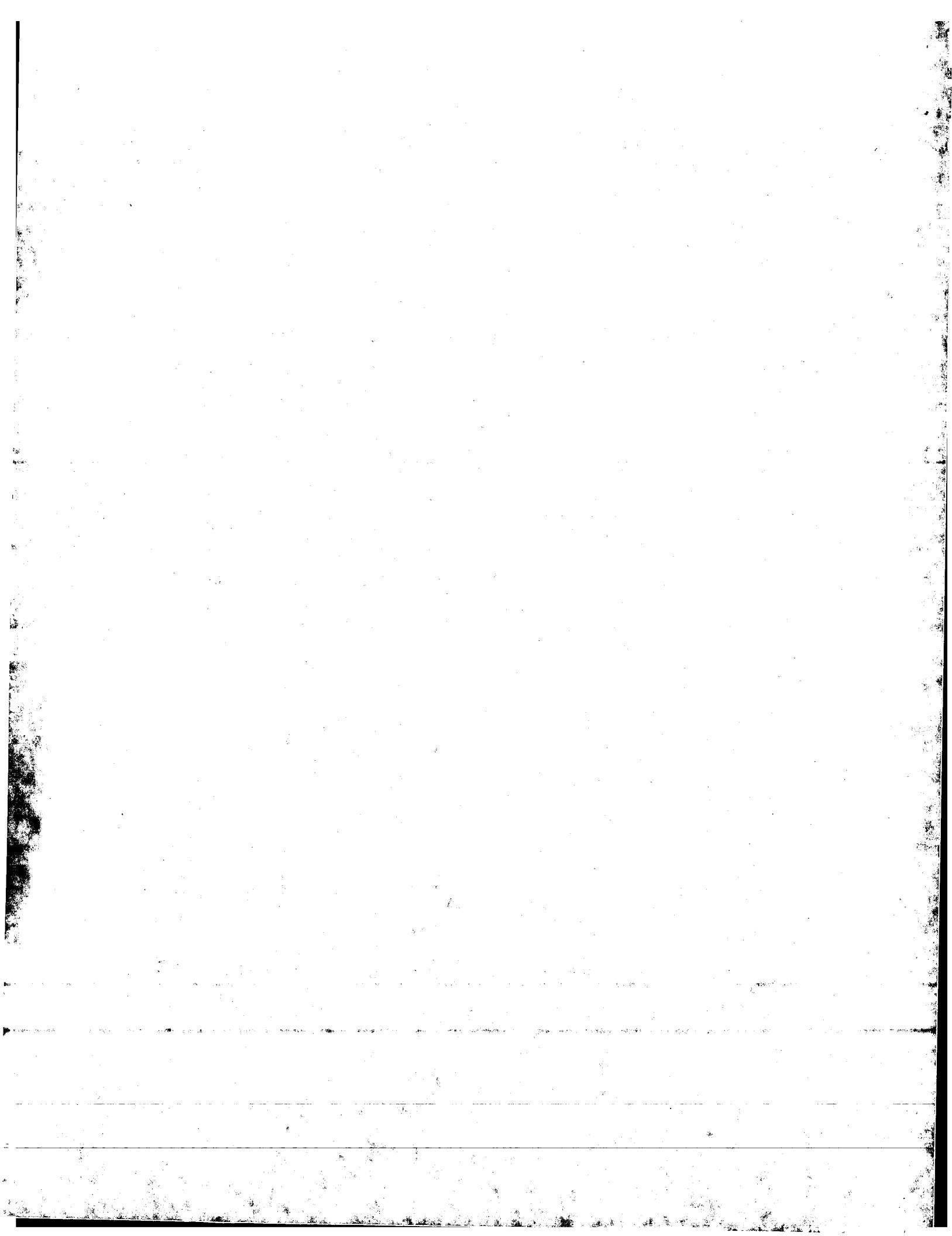
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(19)

Europäisches Patentamt
European Patent Office
Office européen des brevets



(11)

EP 1 321 287 A2

(12)

EUROPEAN PATENT APPLICATION

(43) Date of publication:
25.06.2003 Bulletin 2003/26

(51) Int Cl.7: B31F 1/07, A61F 13/15

(21) Application number: 02258801.6

(22) Date of filing: 19.12.2002

(84) Designated Contracting States:
AT BE BG CH CY CZ DE DK EE ES FI FR GB GR
IE IT LI LU MC NL PT SE SI SK TR

Designated Extension States:

AL LT LV MK RO

(30) Priority: 21.12.2001 US 36770
05.09.2002 US 236993

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(54) An embossing apparatus and method for degrading a web in the machine direction while preserving cross-machine direction strength

(57) An embossing system (20) is provided for embossing and perforating a web (34) having a first embossing roll (22) having embossing elements (24) and a second embossing roll (22) having embossing elements (34), wherein at least a portion of the embossing

elements of the first and second embossing rolls are substantially oriented in the cross-machine direction. The embossing roll may be crowned, may have alignment means, and may be provided with precision gearing.

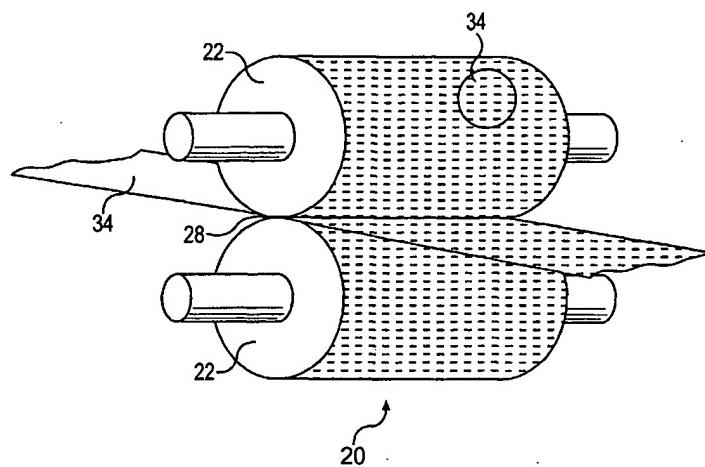


FIG. 1A

Description

[0001] This application claims priority of U.S. Patent Application Serial No. 10/036,770, filed December 21, 2001 and U.S. Patent Application Serial No. 10/236,993, filed September 5, 2002.

5 [0002] The present invention relates to an apparatus and method for embossing a moving web of material, such as paper, to create a functional controlled degradation of the machine direction strength of the web while limiting degradation of the cross-machine direction strength of the web. In one embodiment, the present invention relates to an apparatus and method for embossing a moving web using an embossing system having perforate embossing elements oriented to define perforating nips substantially oriented in the cross-machine direction to improve the flexibility, feel, bulk, and absorbency of the paper. In another embodiment, the present invention relates to an apparatus and method for embossing a moving web using an embossing system having embossing elements oriented to define perforating nips substantially oriented in the cross-machine direction to improve the flexibility, feel, bulk, and absorbency of the paper, while reducing circumferential alignment drift of the embossing rolls in the machine direction and reducing the possibility of a caliper profile. In addition, the invention relates to an apparatus and method of aligning embossing rolls 10 having cross-machine direction embossing elements to attain engagement.

15 [0003] Embossing is the act of mechanically working a substrate to cause the substrate to conform under pressure to the depths and contours of a patterned embossing roll. Generally the web is passed between a pair of embossing rolls that, under pressure, form contours within the surface of the web. During an embossing process, the roll pattern is imparted onto the web at a certain pressure and/or penetration. In perforate embossing the embossing elements 20 are configured such that at least a portion of the web located between the embossing elements is perforated. As used herein, generally, "perforated" refers to the existence of either (1) a macro-scale through aperture in the web or (2) when a macro-scale through aperture does not exist, at least incipient tearing such as would increase the transmittivity of light through a small region of the web or would decrease the machine direction strength of a web by at least 15% for a given range of embossing depths.

25 [0004] Embossing is commonly used to modify the properties of a web to make a final product produced from that web more appealing to the consumer. For example, embossing a web can improve the softness, absorbency, and bulk of the final product. Embossing can also be used to impart an appealing pattern to a final product.

30 [0005] Embossing is carried out by passing a web between two or more embossing rolls, at least one of which carries the desired emboss pattern. Known embossing configurations include rigid-to-resilient embossing and rigid-to-rigid embossing.

35 [0006] In a rigid-to-resilient embossing system, a single or multi-ply substrate is passed through a nip formed between a roll whose substantially rigid surface contains the embossing pattern as a multiplicity of protuberances and/or depressions arranged in an aesthetically-pleasing manner, and a second roll, whose substantially resilient surface can be either smooth or also contain a multiplicity of protuberances and/or depressions which cooperate with the rigid surfaced patterned roll. Commonly, rigid rolls are formed with a steel body which is either directly engraved upon or which can contain a hard rubber-covered, or other suitable polymer, surface (directly coated or sleeved) upon which the embossing pattern is formed by any convenient method such as, for example, being laser engraved. The resilient roll may consist of a steel core provided with a resilient surface, such as being directly covered or sleeved with a resilient material such as rubber, or other suitable polymer. The rubber coating may be either smooth or engraved with a pattern. The pattern on the resilient roll may be either a mated or a non-mated pattern with respect to the pattern carried on the rigid roll.

40 [0007] In the rigid-to-rigid embossing process, a single-ply or multi-ply substrate is passed through a nip formed between two substantially rigid rolls. The surfaces of both rolls contain the pattern to be embossed as a multiplicity of protuberances and/or depressions arranged into an aesthetically-pleasing manner where the protuberances and/or depressions in the second roll cooperate with those patterned in the first rigid roll. The first rigid roll may be formed, for example, with a steel body which is either directly engraved upon or which can contain a hard rubber-covered, or other suitable polymer, surface (directly coated or sleeved) upon which the embossing pattern is engraved by any conventional method, such as by laser engraving. The second rigid roll can be formed with a steel body or can contain a hard rubber covered, or other suitable polymer, surface (directly coated or sleeved) upon which any convenient pattern, such as a matching or mated pattern, is conventionally engraved or laser-engraved. In perforate embossing, a rigid-to-rigid embossing system is typically used. However, a rigid-resilient configuration can also be used for perforate embossing.

45 [0008] When substantially rectangular embossing elements have been employed in perforate embossing, the embossing elements on the embossing rolls have generally been oriented so that the long direction axis, i.e., the major axis, of the elements is in the machine direction. That is, the major axis of the elements is oriented to correspond to the direction of the running web being embossed. These elements are referred to as machine direction elements. As a result, the elements produce perforations which extend primarily in the machine direction and undesirably decrease the strength of the web in the cross-machine direction. This orientation improves absorbency and softness, but can

degrade, i.e., reduce the strength of, the web primarily in the cross-machine direction while less significantly degrading the strength of the web in the machine direction. As a result, the tensile strength of the web in the cross-machine direction is reduced relatively more, on a percentage basis, than that of the machine direction. In addition, the cross-machine direction strength of the base sheet is typically less than that of the machine direction strength. As a result, by embossing with machine direction elements, the cross-machine direction strength is even further weakened and, accordingly, because the finished product will fail in the weakest direction, the product will be more likely to fail when stressed in the cross-machine direction. Often, it is preferred that the web is "square," i.e., has a machine direction/cross-machine direction tensile ratio close to 1.0.

5 [0009] Cross-machine direction tensile strength can be associated with consumer preference for paper toweling. In particular, consumers prefer a strong towel, of which cross-machine direction and machine direction strength are two components. Because the un-embossed base sheet is typically much stronger in the machine direction than the cross-machine direction, a process is desired which results in both improved absorbency and softness without sustaining excessive losses in cross-machine direction tensile strength.

10 [0010] U.S. Patent Application Ser. No. 10/036,770, addressed at least the above described problem by providing at least two embossing rolls, wherein at least a portion of the elements are oriented to provide perforating nips which are substantially in the cross-machine direction and are configured to perforate the web, thereby allowing relatively greater degradation, i.e., a reduction of strength, of the web in the machine direction while preserving more of the cross-machine direction strength. It was observed, however, that at times in operation of the above invention the circumferential alignment of the embossing rolls tended to drift in the machine direction. Such drifting could possibly lead 15 to interference between the adjacent engaging embossing elements of the embossing rolls which could cause unwanted degradation of the paper web and, ultimately, could lead to damage or destruction of the elements themselves. In addition, the drifting could lead to a non-uniform final product.

20 [0011] It has been discovered that the machine direction drifting is caused, at least in large part, by the gearing commonly used on embossing rolls. In standard gearing mechanisms, the gears are constructed by first forming the 25 gears out of metal block. To achieve the hardness levels required for operating conditions, the gears are then heat treated. The heat treating process typically causes deformation in the gears and, therefore, the gears lack the necessary precision for certain applications. When machine direction elements alone are used, in some cases, this lack of precision may be acceptable because, as noted above, the drift is in the machine direction. Thus, in those cases, the 30 circumferential alignment drift will only lead to a change in the embossing pattern, but will not lead to interference of the embossing elements. When perforate embossing a paper web with cross-machine direction elements, on the other hand, the circumferential alignment drift can lead to interference between the elements.

35 [0012] The present invention addresses at least embossing roll circumferential alignment drift by providing a cross-machine embossing system without circumferential drift by providing a precision gearing system for use with the cross-machine direction element embossing rolls. In particular, the present invention addresses at least embossing roll circumferential alignment drift by providing a precision gearing system that will substantially prevent the embossing rolls from shifting circumferentially with respect to one another in the machine direction as a web is perforate embossed. According to one embodiment of the present invention, the gears are constructed by first heat treating a metal base material to achieve the desired hardness. The base material is then hobbed to form the gear structure. In addition, precision hubs are provided to maintain the concentricity of the embossing roll gears. In particular, conventional hubs 40 and bushings are formed separately. When the bushings are press-fit between the hub and the journal, distortion of the hub can occur, thereby potentially changing the concentricity of the hub. In the current invention, the hub and bushing are machined together after the bushing is press-fitted between the hub and an arbor. Because the press-fitting takes place before the machining, any distortion is significantly reduced or eliminated and the concentricity of the hub is maintained.

45 [0013] In addition to the above, the initial alignment for engagement of the cross-machine direction element embossing rolls can be time consuming. Alignment is important because if the rolls are improperly aligned the opposing elements can come into contact with one another, causing damage to the elements. In traditional embossing rolls having machine direction elements, alignment can be accomplished with less difficulty because the operator aligning the rolls can visually see the alignment of the elements. When the embossing elements are oriented in the cross-machine direction, on the other hand, the operator does not generally have the visual access necessary to align the rolls.

50 [0014] One alignment process according to the invention is described as follows. First, the operator brings the rolls into close proximity, without allowing the elements to contact. A web, such as a nip impression paper, is then fed through the embossing roll, leaving an imprint of the location of the elements on the web. The imprinted web is analyzed to determine whether the elements will contact each other when brought into closer proximity. Based on the outcome of 55 the imprint, the machine direction alignment of the embossing rolls may be adjusted. After any necessary adjustment, the embossing rolls are brought into closer proximity and a web, such as a nip impression paper, is once again fed through the embossing rolls to determine the relative location or proximity of the elements. This process is repeated until the embossing rolls are in operating position. In addition, anytime one or both of the rolls are removed for servicing,

or the circumferential alignment is changed for any reason, the alignment process must be repeated. Using this method, aligning the rolls can be very time consuming. Those of ordinary skill in the art will understand that any process which achieves the necessary alignment can be used.

5 [0015] A reduction in alignment time is addressed by providing an alignment system on the embossing rolls. In one embodiment according to the present invention, an adjustable collar ring is provided on the first embossing roll. The second embossing roll may have an adjustable collar ring, a fixed collar ring, a machined keyway, or other structure that will permit the alignment with the first embossing roll. The collars are positioned such that when aligned and the emboss rolls are engaged, the embossing elements will not interfere with one another. A key may be provided for alignment of the collars. In another embodiment of the present invention, scribe marks are provided on each of the 10 first and second embossing rolls.

[0016] It has been discovered that when perforating a web in the cross-machine direction a caliper profile can exist. In particular, when perforating a web in the cross-machine direction at operating speeds, in some instances the caliper 15 of the perforated web near the ends of the embossing rolls can be greater than that at the middle of the roll. This caliper profile indicates that a higher degree of perforation was accomplished near the ends of the embossing rolls. It is believed that this profile is a function of the speed of the web as it is perforated due to deflection of the embossing rolls. While deflection also occurs when embossing with elements creating perforations in the machine direction, the deflection seems to be aggravated when embossing to create perforations extending in the cross-machine direction.

20 [0017] The present invention addresses caliper profile by providing at least one crowned embossing roll. In one embodiment two crowned rolls are used. A roll is crowned when the diameter of the center portion of the embossing roll is greater than that at the ends. The roll may be crowned by gradually reducing the diameter of the embossing roll when moving from the center portion of the embossing roll towards the ends of the embossing roll. In another embodiment, the reduction towards the ends of the roll is increased such that the shape of the crown is generally parabolic. In yet another embodiment, the reduction of the roll diameter exists only at the ends of the roll. In still yet another embodiment, the reduction of the roll diameter is a stepped reduction.

25 [0018] Further advantages of the invention will be set forth in part in the description which follows and in part will be apparent from the description or may be learned by practice of the invention. The advantages of the invention may be realized and attained by means of the instrumentalities and combinations particularly pointed out in the appended claims.

30 Summary of the Invention

[0019] As embodied and broadly described herein, the invention includes an embossing system for embossing and perforating at least a portion of a web comprising a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein juxtaposition and engagement of the first and second 35 embossing rolls define a plurality of perforate nips for embossing and perforating the web and wherein at least a predominate number of the embossing elements are configured so as to produce perforating nips which are substantially oriented in the cross-machine direction. In one embodiment, the invention further includes an embossing system wherein substantially all of the embossing elements of the first and second embossing rolls produce perforating nips which are substantially oriented in the cross-machine direction. Further, in one embodiment, the cross-machine embossing elements are at an angle of 85 to 95° from the machine direction, which is equivalent to having a skew of ± 5°.

40 [0020] In another embodiment, the invention includes an embossing system for embossing at least a portion of a web comprising a first embossing roll and at least a second embossing roll, wherein each of the first and second embossing rolls has at least one juxtaposable embossing element capable of producing a perforating nip substantially oriented in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web, and wherein at least a substantial portion of the cross-machine direction elements have at least the ends beveled.

45 [0021] In yet another embodiment, the invention includes an embossing system for embossing and perforating at least a portion of a web comprising a first embossing roll and at least a second embossing roll, wherein each of the first and second embossing rolls has at least one juxtaposable element capable of producing a perforating nip substantially oriented in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web, and wherein the cross-machine direction elements have sidewall angles, the angle between the sidewall and the radial direction on the cross-machine direction sides of the element, juxtaposed so as to be capable of producing a shear line, of less than about 20°. In one embodiment the cross-machine direction elements have cross-machine direction sidewall angles of less than about 17°. In another embodiment the cross-machine direction elements have cross-machine direction sidewall angles of less than about 14°. In yet another embodiment, the cross-machine direction elements have cross-machine direction sidewall angles of less than 11°. In a further embodiment the cross-machine direction elements have cross-machine direction sidewall angles of from about 7° to 11°.

- [0022] In yet another embodiment, the invention includes a method for embossing and perforating at least a portion of a web comprising providing a first embossing roll having embossing elements and providing at least a second embossing roll having embossing elements, wherein at least a predominate number of the embossing elements, when juxtaposed such that they are capable of producing perforate nips, are substantially oriented in the cross-machine direction and wherein the first and second embossing rolls define a perforate nip for embossing and perforating the web and passing the web between the first and second embossing rolls wherein the first and second embossing rolls are configured to result in an element clearance that will achieve a non-picking clearance while achieving at least a 15% reduction in the machine direction tensile strength of the web. We have found that picking may be alleviated by controlling the circumferential alignment of the two rolls. Picking can result from drift caused by local variances in roll diameter or gearing from the ideal.
- [0023] In still yet another embodiment, the invention includes a method for reducing the tensile ratio of a web by embossing and perforating the web comprising passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a plurality of perforating nips for embossing and perforating the web and wherein at least a predominant number of the perforating nips which are substantially oriented in the cross-machine direction. In one embodiment, the invention further includes an embossing system wherein substantially all of the embossing elements of the first and second embossing rolls produce perforating nips which are substantially oriented in the cross-machine direction. Further, in one embodiment, the cross-machine embossing elements are at an angle of 85-95° from the machine direction.
- [0024] In yet another embodiment, the invention includes a method for reducing the tensile ratio of a web by embossing and perforating the web comprising passing a web through an embossing system, wherein the embossing system comprises a first embossing roll and at least a second embossing roll, wherein each of the first and second embossing rolls has at least one juxtaposable embossing element capable of producing a perforating nip substantially oriented in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web and wherein at least a substantial portion of the cross-machine direction elements have at least the ends beveled.
- [0025] In still yet another embodiment, the invention includes a method for reducing the tensile ratio of a web by embossing and perforating the web comprising, passing a web through an embossing system, wherein the embossing system comprises a first embossing roll and at least a second embossing roll, wherein each of the first and second embossing rolls has at least one juxtaposable embossing element capable of producing a perforating nip substantially oriented in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web and wherein the cross-machine direction elements have cross-machine direction sidewall angles of less than about 20°. In one embodiment the cross-machine direction elements have cross-machine direction sidewall angles of less than about 17°. In another embodiment the cross-machine direction elements have cross-machine direction sidewall angles of less than about 14°. In yet another embodiment, the cross-machine direction elements have cross-machine direction sidewall angles of less than about 11°. In still yet another embodiment, the cross-machine direction elements have cross-machine direction sidewall angles of from about 7° to 11°.
- [0026] In another embodiment, the invention includes a method for reducing the tensile ratio of a web by embossing and perforating the web comprising passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a perforate nip for embossing and perforating the web and wherein the first and second embossing rolls are configured to result in an element clearance that will achieve a non-picking clearance.
- [0027] The invention further includes a perforate embossed web having a plurality of cross-machine direction oriented perforations wherein the embossed web has a tensile ratio of less than about 1.2. The invention further includes a perforate embossed web having a transluminance ratio (as defined hereinafter) of at least 1.005. Still further, the invention includes a wet-laid cellulosic perforate embossed web having perforate embossments extending predominately in the cross-machine direction.
- [0028] The invention still further includes a method of embossing and perforating the web comprising passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web, and wherein the tensile ratio of the web is reduced.
- [0029] The invention further includes an embossing system for perforate embossing at least a portion of a web comprising a first embossing roll having embossing elements, and at least a second embossing roll having embossing elements, wherein at least a portion of either the first or second embossing rolls is crowned, and wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web, and

wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction. The invention still further includes an embossing system for embossing and perforating at least a portion of a web comprising a first embossing roll having embossing elements, wherein at least a portion of the first embossing roll is crowned, and at least a second embossing roll having embossing elements, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web, and wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction.

[0030] In another embodiment, the invention includes an embossing roll having embossing elements substantially oriented in the cross-machine direction wherein the embossing roll is crowned.

[0031] In yet another embodiment, the invention includes an embossing system for embossing and perforating at least a portion of a web comprising a first embossing roll having embossing elements, the first embossing roll being in communication with a first gear, and at least a second embossing roll having embossing elements, the second embossing roll being in communication with a second gear, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web, and wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction, and wherein the first gear and the second gear have a precision rating of greater than Q-6. The first gear and the second gear may have a precision rating of at least about Q-8.

[0032] Finally, the invention includes an embossing system for embossing and perforating at least a portion of a web comprising a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the embossing rolls have an alignment means. In one embodiment the first embossing roll has a first alignment means and the second embossing roll has a second alignment means, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web.

[0033] The accompanying drawings, which are incorporated herein and constitute a part of this specification, illustrate an embodiment of the invention, and, together with the description, serve to explain the principles of the invention.

25 Brief Description of the Drawings

[0034] FIGS. 1A-D illustrates embossing rolls having cross-machine direction elements according to an embodiment of the present invention.

[0035] FIG. 2 illustrates cross-machine direction elements according to another embodiment of the present invention.

[0036] FIG. 3 illustrates cross-machine direction elements according to another embodiment of the present invention.

[0037] FIG. 4 illustrates the alignment of the cross-machine direction elements according to an embodiment of the present invention.

[0038] FIG. 5 illustrates the alignment of the cross-machine direction elements according to another embodiment of the present invention.

[0039] FIG. 6 illustrates the alignment of the cross-machine direction elements according to another embodiment of the present invention.

[0040] FIG. 7 illustrates the alignment of the cross-machine direction elements according to yet another embodiment of the present invention.

[0041] FIG. 8 is a photomicrograph illustrating the effect of cross-machine direction elements on a web according to an embodiment of the present invention.

[0042] FIG. 9 is a photomicrograph illustrating the effect of cross-machine direction elements on a web according to another embodiment of the present invention.

[0043] FIG. 10 illustrates the effect of cross-machine direction elements on a web according to yet another embodiment of the present invention.

[0044] FIG. 11 illustrates the effect of cross-machine direction elements on a web according to yet another embodiment of the present invention.

[0045] FIGS. 12A-C are side views of the cross-machine direction elements of embodiments of the present invention having differing wall angles and illustrating the effect of the differing wall angles.

[0046] FIGS. 13A-C are side views of the cross-machine direction elements of embodiments of the present invention having differing wall angles and illustrating the effect of the differing wall angles.

[0047] FIGS. 14A-C are side views of the cross-machine direction elements of yet another embodiment of the present invention having differing wall angles and illustrating the effect of the differing wall angles.

[0048] FIG. 15 depicts a transluminance test apparatus.

[0049] FIGS. 16A-B illustrate embossing rolls having both cross-machine direction and machine direction elements according to an embodiment of the present invention.

[0050] FIGS. 17A-C illustrate the effects of over embossing a web portion in the machine direction and cross-machine direction when using rigid to resilient embossing as compared to perforate embossing a web as in FIG. 17D.

[0051] FIG. 18 depicts a sectional view of a gear and hub assembly of an embossing roll system usable in an em-

bodiment of the present invention.

[0052] FIG. 19 depicts a sectional view of a hub assembly usable in an embodiment of the present invention.

[0053] FIGS. 20-23 are photomicrographs illustrating the effect of element drift according to an embodiment of the present invention.

5 [0054] FIG. 24 illustrates an alignment ring usable in an embodiment of the present invention.

Detailed Description

[0055] Reference will now be made in detail to the preferred embodiments of the present invention, examples of which are illustrated in the accompanying drawings.

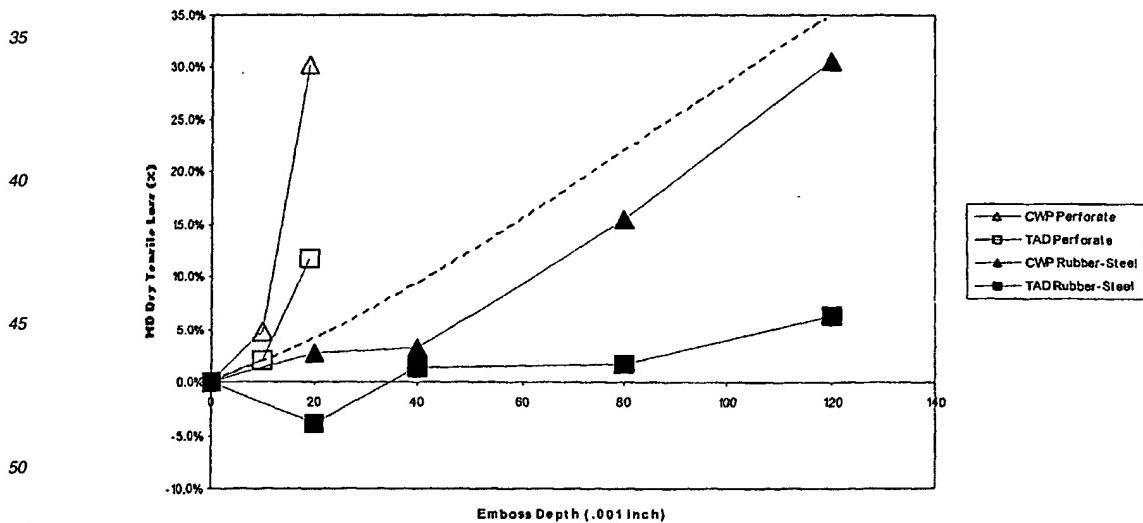
[0056] The present invention can be used to emboss a variety of types of wet-laid cellulosic webs including paper, and the like. The webs can be continuous or of a fixed length. Moreover, embossed webs can be used to produce any art recognized product, including, but not limited to, paper towels, napkins, tissue, or the like. Moreover, the resulting product can be a single ply or a multi-ply paper product, or a laminated paper product having multiple plies. In addition, the present invention can be used with a web made from virgin furnish, recycled furnish, or a web containing both virgin and recycled furnish, synthetic fibers, or any combination thereof.

[0057] In accordance with the invention, as broadly described, the converting process includes an embossing system of at least two embossing rolls, the embossing rolls defining at least one nip through which a web to be embossed is passed. The embossing elements are patterned to create perforations in the web as it is passed through the nip.

[0058] Generally, for purposes of this invention, perforations are created when the strength of the web is locally degraded between two bypassing embossing elements resulting in either (1) a macro scale through-aperture or (2) in those cases where a macro scale through-aperture is not present, at least incipient tearing, where such tearing would increase the transmittivity of light through a small region of the web or would decrease the machine direction strength of a web by at least 15% for a given range of embossing depths. Graph 1 depicts a comparison of the effects on reduction of strength in the machine direction when perforate embossing a web, as defined herein, and non-perforate embossing a web. In particular, a conventional wet pressed base sheet was perforate embossed between two steel rolls. The same base sheet was non-perforate embossed in a rubber to steel configuration. In addition, a through-air-dried base sheet was also perforate and non-perforate embossed. The reduction in machine direction strength was measured for each of the sheets. The results are plotted on Graph 1.

30

Graph 1. Reduction of Machine Direction Tensile Strength



[0059] As shown in Graph 1, when non-perforate embossing either a CWP or TAD web to depths of up to 40 mils, the reduction of paper strength in the machine direction is less than 5%. And, when non-perforate embossing either of the CWP or TAD webs at a depth of 80 mils, the reduction of strength of the web is less than 15%. When perforate embossing a web as disclosed in this invention, a greater reduction in strength of the web can be achieved.

In the example set forth herein, strength reductions of greater than 15% are achieved when perforate embossing at

depths of at least about 15 mils as compared to rubber to steel embossing which can result in these strength losses at emboss depths of over 60 mils. Accordingly, for purposes of this invention, perforation is specifically defined as locally degrading the strength of the web between two bypassing embossing elements resulting in either (1) the formation of a macro scale through-aperture or (2) when a macro scale through-aperture is not formed, at least incipient tearing, where such tearing would either increase the transmittivity of light through a small region of the web or would decrease the machine direction strength of a web by at least the percentages set forth in Graph 1, wherein the "at least" percentages are indicated by the dashed line.

[0060] Not being bound by theory, we believe that the superior strength reduction results achieved using the present invention are due to the location of the local degradation of the web when perforate embossing as compared to when non-perforate embossing. When a web is embossed, either by perforate or non-perforate methods, the portion of the web subject to the perforate or non-perforate nip is degraded. In particular, as a web passes through a non-perforate nip for embossing, the web is stressed between the two embossing surfaces such that the fiber bonds are stretched and sometimes, when the web is over embossed, which is not desired when non-perforate embossing a web, the bonds are torn or broken. When a web is passed through a perforate nip, the web fiber bonds are at least incipiently torn by the stresses caused by the two bypassing perforate elements. As stated above, however, one difference between the two methods appears to be in the location of the at least incipient tearing.

[0061] When a web is over-embossed in a rubber to steel configuration, the male steel embossing elements apply pressure to the web and the rubber roll, causing the rubber to deflect away from the pressure, while the rubber also pushes back. As the male embossing elements roll across the rubber roll during the embossing process, the male elements press the web into the rubber roll which causes tension in the web at the area of the web located at the top edges of the deflected rubber roll, i.e., at the areas at the base of the male embossing elements. When the web is over-embossed, tearing can occur at these high-tension areas. More particularly, FIGS. 17A-C depict rubber to steel embossing of a web at various embossing depths. FIG. 17A depicts embossing of a web at approximately 0 mils. In this configuration the rubber roll pins the web at the points where the web contacts the steel roll element tops. Typically no tearing will occur in this configuration. In FIG. 17B, where the embossing depth is approximately the height of the steel embossing element, the web is pinned at the element tops and at a point between the bases of the adjacent steel elements. As with the configuration depicted in FIG. 17A, tearing does not typically occur in this configuration for conventional embossing procedures. FIG. 17C depicts an embossing depth comparable to or greater than the height of the steel element. In this configuration, the "free span" of the web, i.e., the sections of the web that are not pinned between the rubber and steel rolls, becomes shorter as the rubber material fills the area between the adjacent elements. When web rupturing occurs, it tends to occur near the last location where web movement is possible; that is, the area of degradation 40 is the last area that is filled by the rubber material, namely the corners where the bases of the elements meet the surface of the emboss roll.

[0062] When a web is perforate embossed, on the other hand, the areas of degradation 42, as shown in FIG. 17D, are located along the sides of the perforate embossing element. For clarity, only one pair of cooperating elements are being shown in FIG. 17D. It appears that as a result of this difference the degradation of the web and the resultant reduction of web strength is dramatically different.

[0063] In one embodiment according to the present invention, the embossing rolls have substantially identical embossing element patterns, with at least a portion of the embossing elements configured such that they are capable of producing perforating nips which are capable of perforating the web. As the web is passed through the nip, an embossing pattern is imparted on the web. It is preferred that the embossing rolls be either steel or hard rubber, or other suitable polymer. The direction of the web as it passes through the nip is referred to as the machine direction. The transverse direction of the web that spans the emboss roll is referred to as the cross-machine direction. In one embodiment, a predominant number, i.e., at least 50% or more, of the perforations are configured to be oriented such that the major axis of the perforation is substantially oriented in the cross-machine direction. An embossing element is substantially oriented in the cross-machine direction when the long axis of the perforation nip formed by the embossing element is at an angle of from about 60° to 120° from the machine direction of the web.

[0064] In an embodiment according to the present invention, and as shown in FIG. 1, the converting process includes an embossing system 20 of two embossing rolls 22 defining a nip 28 through which the web 32 to be embossed is passed. According to one embodiment, the embossing rolls 22 are matched (i.e., substantially similar, or at least close to, identical male) embossing rolls. The embossing rolls can be, for example, either steel or hard rubber, or other suitable polymer. The embossing rolls 22 are configured such that the perforations created by the embossing elements 34 are oriented such that the major axis of the perforations extend in the cross-machine direction, i.e., the elements are in the cross-machine direction, although it is possible to envisage configurations in which perforations extending in the cross-machine direction are formed by elements which are longer in the machine direction, although such a configuration would normally be sub-optimal as it would compromise the overall number of perforations which could be formed in the web. Accordingly, when we discuss elements oriented in the cross-machine direction, we are referring to elements that are configured such that the orientation of the perforation formed by those elements extends in the

cross-machine direction, irrespective of the shape of the remainder of the element not contributing to the shape of the nip. While the embossing rolls 22 can also have embossing elements oriented such that the major axis of the elements is in the machine direction, a predominant number, i.e., at least 50% or more, of the elements 34 should be oriented such that they are capable of producing perforating nips extending in the cross-machine direction. In another embodiment, substantially all, i.e., at least more than 75%, of the elements 34 are oriented such that they are capable of producing perforating nips extending in the cross-machine direction. In yet another embodiment, all of the elements are oriented in the cross-machine direction. Moreover, at least about 25% of the cross-machine direction elements are perforating elements. In one embodiment, all of the cross-machine direction elements are perforating elements. Thus, when the web passes through the embossing rolls 22, at least a portion of the cross-machine direction elements are aligned such that the web is perforated such that at least a portion of the perforations are substantially oriented in the cross-machine direction.

[0065] The end product characteristics of a cross-machine direction perforated embossed product can depend upon a variety of factors of the embossing elements that are imparting a pattern on the web. These factors can include one or more of the following: embossing element height, angle, shape, including sidewall angle, spacing, engagement, and alignment, as well as the physical properties of the rolls, base sheet, and other factors. Following is a discussion of a number of these factors.

[0066] An individual embossing element 34 has certain physical properties, such as height, angle, and shape, that affect the embossing pattern during an embossing process. The embossing element can be either a male embossing element or a female embossing element. The height of an element 34 is the distance the element 34 protrudes from the surface of the embossing roll 22. It is preferred that the embossing elements 34 have a height of at least about 15 mils. In one embodiment according to the present invention, the cross-machine direction elements 34 have a height of at least about 30 mils. In another embodiment of the present invention, the cross-machine direction elements 34 have a height of greater than about 45 mils. In yet another embodiment of the invention, the cross-machine elements have a height of greater than about 60 mils. In yet another embodiment, a plurality of the elements 34 on the roll have at least two regions having a first region having elements having a first height and at least a second region having elements having a second height. In one embodiment, the elements 34 have a height of between about 30 to 65 mils. Those of ordinary skill in the art will understand that there are a variety of element heights that can be used, depending upon a variety of factors, such as the type of web being embossed and the desired end product.

[0067] The angle of the cross-machine direction elements 34 substantially defines the direction of the degradation of the web due to cross-machine perforate embossing. When the elements 34 are oriented at an angle of about 90° from the machine direction, i.e., in the absolute cross-machine direction, the perforation of the web can be substantially in the direction of about 90° from the machine direction and, thus, the degradation of web strength is substantially in the machine direction. On the other hand, when the elements 34 are oriented at an angle from the absolute cross-machine direction, degradation of strength in the machine direction will be less and degradation of strength in the cross-machine direction will be more as compared to a system where the elements 34 are in the absolute cross-machine direction.

[0068] The angle of the elements 34 can be selected based on the desired properties of the end product. Thus, the selected angle can be any angle that results in the desired end product. In an embodiment according to the present invention, the cross-machine direction elements 34 can be oriented at an angle of at least about 60° from the machine direction of the web and less than about 120° from the machine direction of the web. In another embodiment, the cross-machine direction elements 34 are oriented at an angle from at least about 75° from the machine direction of the web and less than about 105° from the machine direction of the web. In yet another embodiment, the cross-machine direction elements 34 are oriented at an angle from at least about 80° from the machine direction of the web and less than about 100° from the machine direction of the web. In a preferred embodiment, the cross-machine direction elements 34 are oriented at an angle of about 85-95° from the machine direction.

[0069] A variety of element shapes can be successfully used in the present invention. The element shape is the "footprint" of the top surface of the element, as well as the side profile of the element. It is preferred that the elements 34 have a length (in the cross-machine direction)/width (in the machine direction) (L/W) aspect ratio of at least greater than 1.0, however while noted above as sub-optimal, the elements 34 can have an aspect ratio of less than 1.0. It is further preferred that the aspect ratio be about 2.0. One element shape that can be used in this invention is a hexagonal element, as depicted in FIG. 2. Another element shape, termed an oval, is depicted in FIG. 3. For oval elements, it is preferred that the ends have radii of at least about 0.003" and less than about 0.030" for at least the side of the element forming a perforate nip. In one embodiment, the end radii are about 0.0135". Those of ordinary skill in the art will understand that a variety of different embossing element shapes, such as rectangular, can be employed to vary the embossing pattern.

[0070] In one embodiment, at least a portion of the elements 34 are beveled. In particular, in one embodiment the ends of a portion of the elements 34 are beveled. Oval elements with beveled edges are depicted in FIG. 1. By beveling the edges, the disruptions caused by the embossing elements can be better directed in the cross-machine direction,

thereby reducing cross-machine direction degradation caused by the unintentional machine direction disruptions. The bevel dimensions can be from at least about 0.010" to at least about 0.025" long in the cross-machine direction and from at least about 0.005" to at least about 0.015" in the z-direction. Other elements, such as hexagonal elements, can be beveled, as well.

5 [0071] The cross-machine direction sidewall of the elements 34 defines the cutting edge of the elements 34. According to one embodiment of the present invention, the cross-machine direction sidewalls of the elements 34 are angled. As such, when the cross-machine direction sidewalls are angled, the base of the element 34 has a width that is larger than that of the top of the element. In one embodiment, the cross-machine direction sidewall angle be less than about 20°. In another embodiment, the cross-machine direction sidewall angle be less than about 17°. In yet another embodiment, the cross-machine direction sidewall angle be less than about 14°. Finally, in still yet another embodiment, the cross-machine direction sidewall angle is less than about 11°. It is further preferred that the cross-machine direction sidewall angle be between about 7° and 11°.

10 [0072] When the opposing elements 34 of the embossing rolls are engaged with each other during an embossing process, the effect on the web is impacted by at least element spacing, engagement, and alignment. When perforate embossing, the elements 34 are spaced such that the clearance between the sidewalls of elements of a pair, i.e., one element 34 from each of the opposing embossing rolls 22, creates a nip that perforates the web as it is passed though the embossing rolls 22. If the clearance between elements 34 on opposing rolls is too great, the desired perforation of the web may not occur. On the other hand, if the clearance between elements 34 is too little, the physical properties of the finished product may be degraded excessively or the embossing elements themselves could be damaged. The 15 required level of engagement of the embossing rolls is at least a function of the embossing pattern (element array, sidewall angle, and element height), and the base sheet properties, e.g., basis weight, caliper, strength, and stretch. At a minimum, it is preferred that the clearances between the sidewalls of the opposing elements of the element pair be sufficient to avoid interference between the elements. In one embodiment, the minimum clearance is about a large fraction of the thickness of the base sheet. For example, if a conventional wet press (CWP) base sheet having a 20 thickness of 4 mils is being embossed, the clearance can be at least about 2-3 mils. If the base sheet is formed by a process which results in a web with rather more bulk, such as, for example, a through air dried (TAD) method or by use of an undulatory creping blade, the clearance could desirably be relatively less. Those of ordinary skill in the art will be able to determine the desired element spacing of the present invention based on the factors discussed above 25 using the principles and examples discussed further herein.

25 [0073] As noted above, in one embodiment it is preferred that the height of the elements 34 be at least about 30 mils, and it is further preferred that the height be from about 30 to 65 mils. Engagement, as used herein, is the overlap in the z-direction of the elements from opposing embossing rolls when they are engaged to form a perforating nip. The engagement overlap should be at least 1 mil.

30 [0074] In one embodiment, the engagement is at least about 15 mils. Various engagements are depicted in FIGS. 12-14. In particular, FIG. 12 depicts a 32 mil engagement. That is, the overlap of the elements, in the z-direction, is 32 mils. The desired engagement is determined by a variety of factors, including element height, element sidewall angle, element spacing, desired effect of the embossing elements on the base sheet, and the base sheet properties, e.g., basis weight, caliper, strength, and stretch. Those of ordinary skill in the art will understand that a variety of engagements can be employed based on the above, as well as other factors. It is preferred that the engagement be chosen to 35 substantially degrade the machine direction tensile strength of the web. It is further preferred that the engagement be at least about 5 mils.

40 [0075] In one embodiment, where the element height is about 42.5 mils and the elements have sidewall angles of from about 7° to 11°, the engagement range can be from about 16 to 32 mils. FIG. 12 depicts a 32 mil engagement, where the element heights are 42.5 mils and the sidewall angles are 7°, 9°, and 11°. It is believed that lower sidewall 45 angles make the process significantly easier to run with more controllability and decreased tendency to "picking."

45 [0076] The element alignment also affects the degradation of the web in the machine and cross-machine directions. Element alignment refers to the alignment in the cross-machine direction within the embossing element pairs when the embossing rolls are engaged. FIG. 4 depicts an embodiment including hexagonal embossing elements having a full step alignment, i.e., where the elements are completely overlapped in the cross-machine direction. FIG. 5. depicts 50 an embodiment wherein hexagonal embossing elements are in half step alignment, i.e., where the elements of each element pair are staggered so that half of the engaged portion of their cross-machine direction dimensions overlap. FIG. 6. depicts an embodiment wherein hexagonal embossing elements are in quarter step alignment, i.e., where the elements of each element pair are staggered so that one quarter of the engaged portion of their cross-machine direction dimensions overlap. The embodiment depicted in FIG. 7 is a staggered array, wherein each element pair is in half step 55 alignment with adjacent element pairs. Those of ordinary skill in the art will understand that a variety of element alignments are available for use with this invention, depending upon preferred embossing patterns, web strength requirements, and other factors.

[0077] FIGS. 8-9 depict the effects of various alignments of a hexagonal element arrangement on a web. In the

example depicted in FIG. 8, where the elements are in full step alignment, perforations exist only in the cross-machine direction in the area between the element pairs. However, between the pairs of element pairs, occasional machine direction perforations can be caused in the machine direction. The result is a degradation of strength in both the machine and cross-machine directions. In the example depicted in FIG. 9, the web is embossed by element pairs in half step alignment. In this example, the perforations exist primarily in the cross-machine direction, with some minor perforations caused in the machine direction. Thus, in FIG. 9, machine direction strength is degraded, and cross-machine direction strength is degraded to a lesser extent.

[0078] As noted above, the elements can be both in the machine direction and cross-machine direction. FIG. 16 depicts an emboss roll having cross-machine direction and machine direction hexagonal elements.

[0079] In another embodiment, depicted in FIG. 10, beveled oval elements are in full step alignment. As with the full step hexagonal elements discussed above, in the area between the element pairs perforations exist primarily in the cross-machine direction. However, between the pairs of element pairs, perforations can be caused in the machine direction. The result is a degradation of strength in both the machine and cross-machine directions. In the embodiment depicted in FIG. 11, on the other hand, where the beveled oval elements in a half step alignment are employed, the machine direction perforations are substantially reduced. In particular, between the elements in half step alignment, the perforation lies primarily in the cross-machine direction. Between the element pairs, which are in zero step alignment, primarily pinpoint ruptures exist. These pinpoint ruptures have a minor effect on degradation of the directional properties of the web.

[0080] Those of ordinary skill in the art will understand that numerous different configurations of the above described element parameters, i.e., element shape, angle, sidewall angle, spacing, height, engagement, and alignment, can be employed in the present invention. The selection of each of these parameters may depend upon the base sheet used, the desired end product, or a variety of other factors.

[0081] One factor, which is impacted by these parameters, is "picking" of the web as it is embossed. Picking is the occurrence of fiber being left on the embossing roll or rolls as the web is embossed. Fiber on the roll can diminish the runability of the process for embossing the web, thereby interfering with embossing performance. When the performance of the embossing rolls is diminished to the point that the end product is not acceptable or the rolls are being damaged, it is necessary to stop the embossing process so that the embossing rolls can be cleaned. With any embossing process, there is normally a small amount of fiber left on the roll which does not interfere with the process if the roll is inspected periodically, e.g., weekly, and cleaned, if necessary. For purposes of the invention, we define picking as the deposition of fiber on the rolls at a rate that would require shut down for cleaning of the rolls more frequently than once a week.

Examples

[0082] The following examples exhibit the occurrence of picking observed in certain arrangements of cross-machine direction perforate embossed patterns. This data was generated during trials using steel embossing rolls engraved with the cross-machine direction beveled oval embossing pattern at three different sidewall angles. In particular, the embossing rolls were engraved with three separate regions on the rolls—a 7° embossing pattern, a 9° embossing pattern, and an 11° embossing pattern. Two trials were performed. In the first trial, the embossing rolls had an element height of 45 mils. The base sheet, having a thickness of 6.4 mils, was embossed at engagements of 16, 24, and 32 mils. In the second trial, the steel rolls were modified by grinding 2.5 mils off the tops of the embossing elements, thereby reducing the element height to 42.5 mils and increasing the surface area of the element tops. The base sheet having a thickness of 6.2 mils was embossed at engagements of 16, 24, 28, and 32 mils. For each trial, embossing was performed in both half step and full step alignment.

[0083] The element clearances for each of the sidewall angles of the first and second trials have been plotted against embossing engagement in Graphs 2 and 3, respectively. The broken horizontal line on each plot indicates the caliper of a single ply of the base sheet that was embossed. The graphs have been annotated to show whether fiber picking was observed at each of the trial conditions (half step observation being to the left of the slash, full step observation to the right). The picking results are depicted in Graphs 2 and 3 below.

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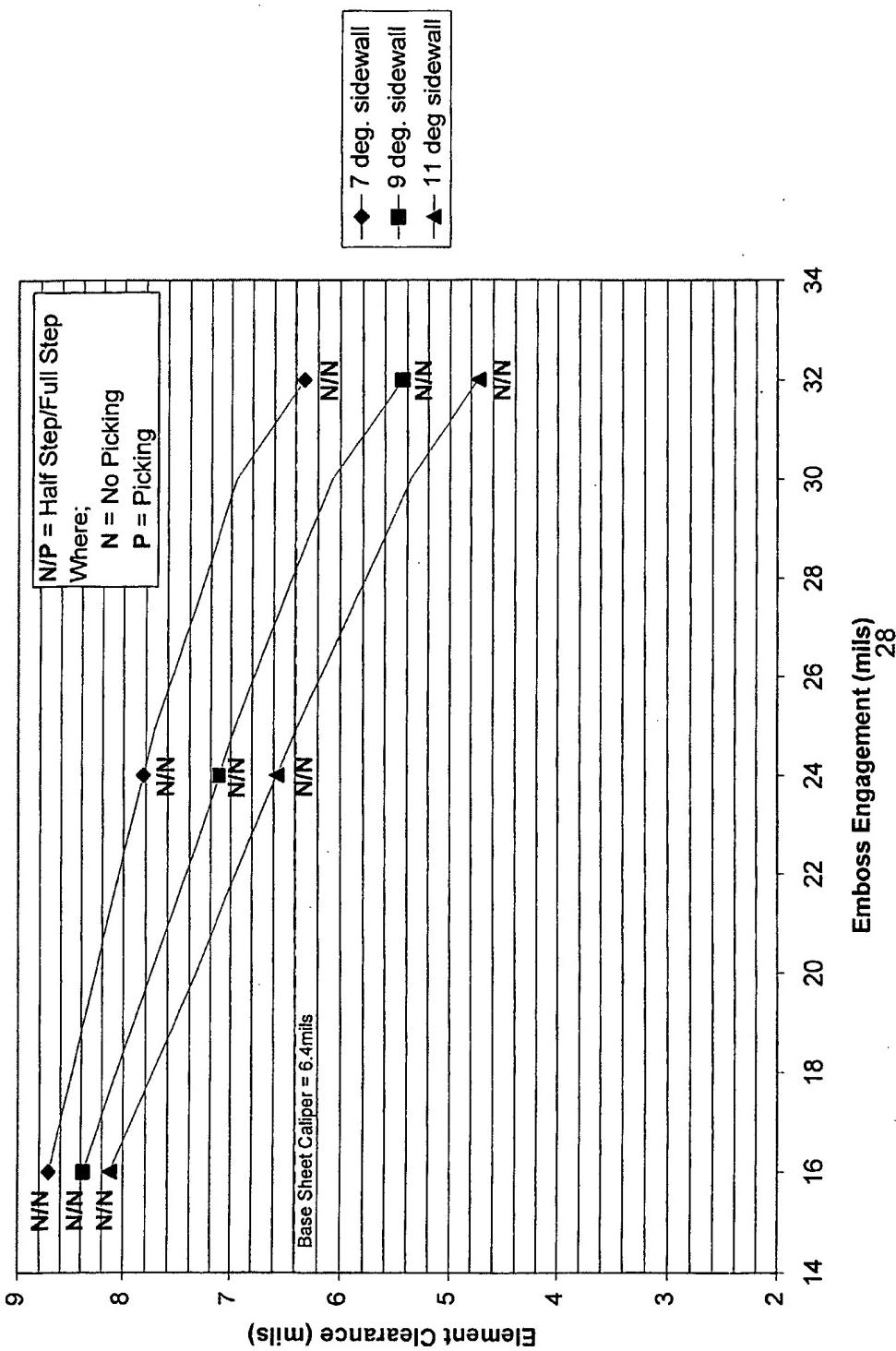
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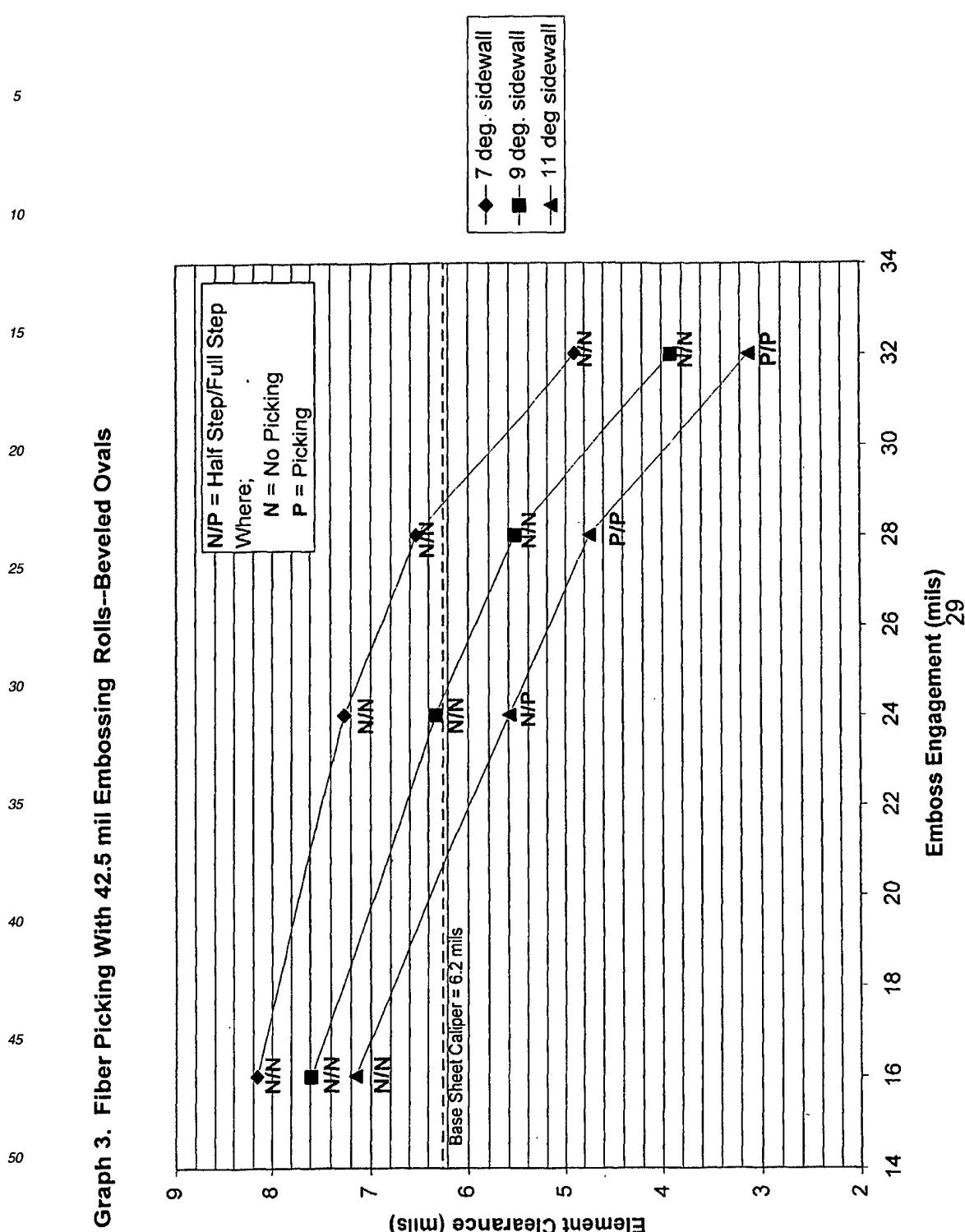
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Graph 2. Fiber Picking With 45 mil Embossing Rolls--Beveled Ovals

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Graph 3. Fiber Picking With 42.5 mil Embossing Rolls--Beveled Ovals

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[0084] Graph 2 shows that for this particular trial using embossing rolls having a 45 mil element height, picking did

not occur at any of the sidewall angles. However, as shown in Graph 3, when the embossing rolls having a 42.5 mil element height were run, fiber picking was observed on the 11° sidewall angle elements at the higher embossing engagements, i.e., 24, 28, and 32 mils. No fiber picking was encountered with elements having sidewall angles of 7° or 9°.

5 [0085] Based on the observed data, it appears that picking is a function of the element height, engagement, spacing, clearance, sidewall angle, alignment, and the particular physical properties of the base sheet, including base sheet caliper. An example of element clearance can be seen in FIG. 12, where the side profiles of the 42.5 mil elements (having 7°, 9°, and 11° sidewall angles) at 32 mil embossing engagement are shown. Clearance is the distance between adjacent engaging embossing elements. As noted above, the caliper of the embossed sheet for this trial was 6.2 mils.
 10 As shown in FIG. 12, the calculated or theoretical clearance at 7° is 0.004906" (4.906 mils), the clearance at 9° is 0.003911" (3.911 mils), and the clearance at 11° is 0.00311" (3.11 mils). Thus, for this trial at a 32 mil engagement, picking was observed only when the clearance was less than about ½ of the caliper of the sheet. Compare this to the clearances shown in FIG. 13. FIG. 13 depicts the sidewall profiles of the 42.5 mil elements at 28 mil embossing engagement. In this arrangement, the calculated or theoretical clearance at 7° is 0.006535" (6.535 mils), the clearance at 9° is 0.005540" (5.540 mils), and the clearance at 11° is 0.004745" (4.745 mils). In this trial, picking was observed when the clearance was less than about 3/4 of the caliper of the sheet. Note, however, that when embossing at 32 mils, as described above, picking did not occur at 9°, while the clearance was less than 4.745 mils. FIG. 14 depicts the sidewall profiles of the 42.5 mil elements at 24 mil engagement. In this arrangement, the clearance at 11° is 0.005599" (5.599 mils), slightly less than the caliper of the sheet. As shown on Graph 3, picking did occur for these elements, but only when the elements were in full step alignment and not when in half step alignment. And, as shown in Graph 2, picking did not occur at all, at any angle, engagement, or alignment, for the 45 mil embossing rolls.

15 [0086] Thus, based on the collected data, picking can be controlled by varying element height, engagement, spacing, clearance, alignment, sidewall angle, roll condition, and the physical properties of the base sheet. Based upon the exemplified information, those of ordinary skill in the art will understand the effects of the various parameters and will be able to determine the various arrangements that will at least achieve a non-picking operation, i.e., the configuration required to avoid an unacceptable amount of picking based on the factors discussed above, and, hence, produce acceptable paper products with a process that does not require excessive downtime for roll cleaning.

20 [0087] To establish the effectiveness of the various element patterns in perforating the web in the cross-machine direction, and thereby degrading machine direction strength while maintaining cross-machine direction strength, a test was developed, the transluminance test, to quantify a characteristic of perforated embossed webs that is readily observed with the human eye. A perforated embossed web that is positioned over a light source will exhibit pinpoints of light in transmission when viewed at a low angle and from certain directions. The direction from which the sample must be viewed, e.g., machine direction or cross-machine direction, in order to see the light, is dependent upon the orientation of the embossing elements. Machine direction oriented embossing elements tend to generate machine direction ruptures in the web which can be primarily seen when viewing the web in the cross-machine direction. Cross-machine direction oriented embossing elements, on the other hand, tend to generate cross-machine direction ruptures in the web which can be seen primarily when viewing the web in the machine direction.

25 [0088] The transluminance test apparatus, as depicted in FIG. 15, consists of a piece of cylindrical tube 44 that is approximately 8.5" long and cut at a 28° angle. The inside surface of the tube is painted flat black to minimize the reflection noise in the readings. Light transmitted through the web itself, and not through a rupture, is an example of a non-target light source that could contribute to translucency noise which could lead non-perforate embossed webs to have transluminance ratios slightly exceeding 1.0, but typically by no more than about 0.05 points. A detector 46, attached to the non-angled end of the pipe, measures the transluminance of the sample. A light table 48, having a translucent glass surface, is the light source.

30 [0089] The test is performed by placing the sample 50 in the desired orientation on the light table 48. The detector 46 is placed on top of the sample 50 with the long axis of the tube 44 aligned with the axis of the sample 50, either the machine direction or cross-machine direction, that is being measured and the reading on a digital illuminometer 52 is recorded. The sample 50 is turned 90° and the procedure is repeated. This is done two more times until all four views, two in the machine direction and two in the cross-machine direction, are measured. In order to reduce variability, all four measurements are taken on the same area of the sample 50 and the sample 50 is always placed in the same location on the light table 48. To evaluate the transluminance ratio, the two machine direction readings are summed and divided by the sum of the two cross-machine direction readings.

35 [0090] To illustrate the results achieved when perforate embossing with cross-machine direction elements as compared to machine direction elements, a variety of webs were tested according to the above described transluminance test. The results of the test are shown in Table 1.

Table 1.

Transluminance Ratios					
	Basis Weight (lbs/ream)	Creping Method (Blade)	Emboss Alignment	Emboss Pattern	Transluminance Ratio
5	30	Undulatory	Full Step	CD Beveled Oval	1.074
	30	Undulatory	Half Step	CD Beveled Oval	1.056
10	32	Undulatory	Half Step	CD Beveled Oval	1.050
	30	Undulatory	Half Step	CD Oval	1.047
15	31	Undulatory	Half Step	CD Oval	1.044
	31	Undulatory	Full Step	CD Oval	1.043
20	30	Undulatory	Full Step	CD Beveled Oval	1.040
	32	Undulatory	Half Step	CD Beveled Oval	1.033
25	30	Undulatory	Half Step	CD Beveled Oval	1.033
	30	Undulatory	Full Step	CD Oval	1.027
30	32	Undulatory	Half Step	CD Beveled Oval	1.025
	30	Undulatory	Half Step	CD Oval	1.022
35	31	Undulatory	Full Step	CD Oval	1.018
	20	Undulatory	Half Step	CD Beveled Oval	1.015
40	30	Undulatory	Half Step	CD Beveled Oval	1.012
	30	Undulatory	Full Step	CD Beveled Oval	1.006
45	28	Standard	Unknown	MD Perforated	1.000
	24	Undulatory	Half Step	MD Perforated	0.988
50	22	Standard	Unknown	MD Perforated	0.980
	29	Undulatory	Half Step	MD Perforated	0.966
55	29	Undulatory	Half Step	MD Perforated	0.951
	31	Undulatory	Half Step	MD Perforated	0.942
	29	Undulatory	Half Step	MD Perforated	0.925

[0091] A transluminance ratio of greater than 1.000 indicates that the majority of the perforations are in the cross-machine direction. For embossing rolls having cross-machine direction elements, the majority of the perforations are in the cross-machine direction. And, for the machine direction perforated webs, the majority of the perforations are in the machine direction. Thus, the transluminance ratio can provide a ready method of indicating the predominant orientation of the perforations in a web.

[0092] As noted above, perforated embossing in the cross-machine direction preserves cross-machine direction tensile strength. Thus, based on the desired end product, a web perforate embossed with a cross-machine direction pattern will exhibit one of the following when compared to the same base sheet embossed with a machine direction pattern: (a) a higher cross-machine direction tensile strength at equivalent finished product caliper, or (b) a higher caliper at equivalent finished product cross-machine direction tensile strength.

[0093] Furthermore, the tensile ratio (a comparison of the machine direction tensile strength to the cross-machine direction tensile strength--MD strength/CD strength) of the cross-machine perforate embossed web typically will be at or below the tensile ratio of the base sheet, while the tensile ratio of the sheet embossed using prior art machine direction perforate embossing typically will be higher than that of the base sheet. These observations are illustrated by the following examples.

[0094] Higher cross-machine direction strength at equivalent caliper is demonstrated in Table 2. This table compares two products perforate embossed from the same base sheet--a 29 pounds per ream (lbs/R), undulatory blade-creped, conventional wet press (CWP) sheet.

Table 2.

Increased CD Strength at Equivalent Caliper					
	Emboss (perforate)	Basis Wt. (lbs/ R)	Caliper (mils)	MD Dry Tensil (g/3")	CD Dry Tensil (g/3")
5	CD Hexagonal	29.1	144	3511	3039
10	MD Hexagonal	29.2	140	4362	1688

[0095] As shown in Table 2, the cross-machine direction perforate embossed web has approximately the same caliper as the machine direction perforate embossed web (144 vs. 140 mils, respectively), but its cross-machine direction dry tensile strength (3039 g/3") is considerably higher than that of the machine direction hexagonal-embossed web (1688 g/3"). In addition, compared to the tensile ratio of the base sheet (1.32), the cross-machine direction perforate embossed web has a lower ratio (1.16), while the machine direction perforate embossed web has a higher ratio (2.58). Thus the method of the present invention provides a convenient, low cost way of "squaring" the sheet—that is, bringing the tensile ratio closer to 1.0.

[0096] Higher caliper at equivalent finished product cross-machine direction tensile strength is illustrated by three examples presented in Table 3. For each example a common base sheet (identified above each data set) was perforate embossed with a cross-machine direction and a machine direction oriented pattern (Hollow Diamond is a machine direction oriented perforate emboss).

Table 3.

Increased Caliper at Equivalent CD Tensile Strength					
	Emboss (perforate)	Basis Wt. (lbs/ R)	Caliper (mils)	MD Dry Tensile (g/3")	CD Dry Tensile (g/3")
25	Base Sheet—undulatory blade-creped, CWP base sheet with tensile ratio = 1.32				
30	CD Quilt	28.8	108	4773	4068
	MD Quilt	28.8	78	6448	3880
35	Base Sheet—undulatory blade-creped, CWP base sheet with tensile ratio = 1.32				
	CD Quilt	29.5	154	2902	2363
	MD Quilt	29.5	120	5361	2410
40	Base Sheet—undulatory blade-creped, CWP base sheet with tensile ratio = 1.94				
	CD Oval	24.6	75	4805	2551
45	Hollow Diamond	24.1	56	5365	2364

[0097] In each case, the cross-machine direction perforate embossed product displays enhanced caliper at equivalent cross-machine direction dry tensile strength relative to its machine direction perforate embossed counterpart. Also, the cross-machine direction perforate embossed product has a lower tensile ratio, while the machine direction perforate embossed product a higher tensile ratio, when compared to the corresponding base sheet.

[0098] The current invention further allows for a substantial reduction in base paper weight while maintaining the end product performance of a higher basis weight product. As shown below in Table 4, wherein the web is formed of recycled fibers, the lower basis weight cross-machine direction perforate embossed towels achieved similar results to machine direction perforate embossed toweling made with higher basis weights.

Table 4.

Performance Comparisons.					
	EMBOSS	Hollow Diamond (MD Perforate)	CD Oval (CD Perforate)	Hollow Diamond (MD Perforate)	CD Oval (CD Perforate)
5	BASIS WT (LBS/ REAM)	24.1	22.2	31.3	28.9
10	CALIPER	56	62	76	81
15	DRY MD TENSILE (g/3")	5365	5057	5751	4144
20	DRY CD TENSILE (g/3")	2364	2391	3664	3254
25	MD STRETCH (%)	7.6	8.1	8.8	10.1
30	CD STRETCH (%)	6.3	6.1	5.5	5.3
35	WET MD CURED TENSILE (g/3")	1236	1418	1409	922
40	WET CD CURED TENSILE (g/3")	519	597	776	641
45	MacBeth 3100 BRIGHTNESS (%)	72.3	72.6	73.3	73.4
50	SAT CAPACITY (g/m²)	98	102	104	119
55	SINTECH MODULUS	215	163	232	162
60	BULK DENSITY	367	405	340	385
65	WET RESILIENCY (RATIO)	0.735	0.725	0.714	0.674

[0099] In Table 4, two comparisons are shown. In the first comparison, a 24.1 lbs/ream machine direction perforated web is compared with a 22.2 lbs/ream cross-machine direction perforated web. Despite the basis weight difference of 1.9 lbs/ream, most of the web characteristics of the lower basis weight web are comparable to, if not better than, those of the higher basis weight web. For example, the caliper and the bulk density of the cross-machine direction perforated web are each about 10% higher than those of the machine direction perforated web. The wet and dry tensile strengths of the webs are comparable, while the Sintech modulus of the cross-machine direction perforated web (i.e., the tensile stiffness of the web, where a lower number is preferred) is considerably less than that of the machine direction perforated web. In the second comparison, similar results are achieved in the sense that comparable tensile ratios and physicals can be obtained with a lower basis weight web. Paradoxically, consumer data indicates that the 28#29C8 product was rated equivalent to the 30.5#HD product while the 22#30C6 product was at statistical parity with the 20204 product, but was possibly slightly less preferred than the 20204 product.

[0100] In one embodiment of the present invention, precision gearing and precision hubs are used to significantly reduce or eliminate circumferential alignment drift of the embossing rolls. In particular, in a perforate embossing operation, the opposing perforate embossing elements on the embossing rolls are in close proximity to one another. As the embossing rolls rotate during the perforate embossing process, the embossing rolls may have a tendency to drift circumferentially relative to one another. If the embossing rolls drift circumferentially, it is possible that the cross-machine direction elements will interfere with each other, potentially leading to unwanted degradation of the paper web and, ultimately, to damage or destruction of the elements themselves.

[0101] Precision gearing and precision hubs can be used to significantly reduce or eliminate circumferential alignment

drift of the embossing rolls. In one embodiment, a precision gear used in the present invention is formed of pre-heat treated material. In another embodiment, a precision gear used in the present invention is formed by precision grinding the stock material, i.e., a ground gear. In yet another embodiment, shaved gears are used.

[0102] FIG. 18 depicts the end of an embossing roll 22, including a journal 60. The journal 60 is in communication with the embossing roll 22 and transmits rotational movement from the gearing system to the embossing roll 22. Also shown in FIG. 18 is the gear assembly. The gear assembly includes a gear 66, a bushing 64, and a hub 62. The hub 62 and bushing 64 are in direct communication. In particular, the bushing 64 is press-fit into the inner diameter of the hub 62. In addition, the gear 66 and hub 62 are also in direct communication. In operation, the gear 66 transmits rotational movement to the hub 62 and bushing 64, which in turn transmit rotational movement to the journal 60 and embossing roll 22. In the embodiment depicted in FIG. 18 the gear is external to the roll. Those of ordinary skill in the art will understand, however, that the gear 66 may be integral with the embossing roll 22.

[0103] The precision gearing for the present invention may have at least two elements. First, the gear may be formed with high machine tolerances. Second, the hub and bushing, in which the journal rests, may be formed with high tolerances in order to maintain the concentricity of the embossing roll.

[0104] As noted above, in standard gearing mechanisms the gears are constructed by first forming the gears out of metal block. To achieve the hardness levels required for operating conditions, conventional gears are heat treated after the gear teeth are formed. The heat treating process typically causes deformation in the gears and, therefore, the gears lack the necessary precision for certain applications. There are three major techniques for improving the accuracy of gearing which can be used singly or in combination to achieve the required degree of precision: use of pre-heat treated

steel, shaving, and precision grinding. In one embodiment of the present invention, the gear is formed of a base material that has been heat treated, i.e., a pre-heat treated base material, thus obviating potential deformations created by heat-treating after the teeth are formed. The base material can be carbon steel, iron, or other materials or alloys known to those of ordinary skill in the art, or later discovered, to have sufficient hardness for the present application. One steel that has been used is 4150 HR STL RND, which has been pre-heat treated to 28-32 Rockwell C. The base material is then hobbed to form the gear structure. The hobbing process includes machining away the base material and then, if even higher precision is required, shaving or precision grinding of the remaining material can be used to form the precision gear. Precision grinding can also be used to improve precision in gears that have been heat-treated after hobbing. The pitch line TIR (total indicated runout, as measured according to ANSI Y14.5M) on the gear should not exceed 0.001". Because heat treating is not required after the gear is formed by the hobbing process when pre-heat treated steel is used, the gear is not distorted after the gear has been formed.

[0105] In another embodiment of the present invention, the gears are shaved gears. Shaved gears may be formed using the following process. First, the non-pre-heat treated material is hobbed. While the process is similar to the hobbing process described above, the gear is hobbed to be larger than the desired final dimensions. Next the gear is heat treated. After the heat treatment, the gear is then re-hobbed according to the desired final dimensions.

[0106] In yet another embodiment of the present invention, the gears are precision ground. Precision in gearing is identified by a grading scale. In particular, the AGMA (American Gear Manufacturers Association) rates the precision, or quality, of a gear on a "Q" scale. (See "Gear Classification and Inspection Handbook," ANSI/AGMA 2000-A88 (March 1988).) For example, the highest precision can generally be found in a ground gear. Ground gears generally have a precision grading of Q-10. Hobbed gears, formed from pre-heat treated material as described above, generally have a precision grading of Q-8. Heat treated gears, on the other hand, generally have a grading of Q-6 or less. The precision gears of the present invention should have a precision rating of greater than Q-6. In one embodiment the precision gears have a precision rating of at least about Q-8. In another embodiment of the present invention, the gears have a precision rating of at least about Q-10. Those of ordinary skill in the art will be able to select the appropriate precision gear based on a variety of factors, including precision desired and cost of gearing.

[0107] When using a precision gear, a precision hub assembly may also be used. The hub assembly is depicted in FIG. 19. The hub assembly includes the hub 62 and the bushing 64. According to one embodiment, the hub 62 is in press-fit communication with the bushing 64. The hub assembly is capable of receiving the embossing roll journal. Moreover, the hub assembly is capable of transmitting rotational movement to the journal. In one embodiment, the hub assembly is precision formed. Referring to FIG. 19, the precision hub assembly of the present invention is formed by machining the hub 62 and the bushing 64 together. In particular, the hub 62 is placed on an arbor 68 and the bushing 64 is then press-fit between the hub 62 and the arbor 68. The hub 62 and bushing 64 are then machined to the appropriate dimensions for the application. In particular, the outer diameter of the hub 62 and bushing 64, and the face of the hub 62 and bushing 64 are machined as an assembly. After machining, the hub assembly is removed from the arbor and placed in communication with the embossing roll journal. The precision formed hub assembly is capable of providing concentricity for the embossing roll when it is rotating. A hub may be considered a precision hub when the tolerances are such that the effect is a reduction or elimination in the circumferential alignment drift of the embossing rolls. In particular, tolerance should be between approximately 0.00 - and 0.0003" TIR on the hub assembly outer diameter. In many cases, it will be advantageous to mount the gears to the roll using a bolt pattern which allows the

hub to be only mounted when the hub is at a fixed angular position on the roll. Often this is achieved by using uneven angular spacing of the bolt holes.

[0108] The resulting improvement from using precision gearing as compared to standard gearing is evidenced by a reduction in the circumferential alignment drift of the embossing rolls when using precision gearing. Circumferential alignment drift in the embossing rolls is evidenced by nonuniformity of the clearance between adjacent engaged embossing elements. Clearance, according to the present invention, is the distance between adjacent engaging embossing elements. Accordingly, when the ranges of clearance differences between the elements is significant, embossing roll circumferential alignment drift may be present.

[0109] FIGS. 20 - 23 are photomicrographs showing the clearances between adjacent engaging embossing elements for two different embossing roll sets. In particular, FIGS. 20 and 21 are photomicrographs of a web that has been cross-machine direction perforate embossed by embossing rolls having standard gearing. FIGS. 20 and 21 show the amount of drift between adjacent elements for one revolution of the embossing roll set. FIG. 20 depicts the closest clearance between the elements while FIG. 21 depicts the furthest clearance between the elements. Comparing FIGS. 20 and 21, the difference between the closest and furthest clearance is significant, thereby reflecting a significant circumferential drift in alignment between the embossing rolls.

[0110] FIGS. 22 and 23, on the other hand, are photomicrographs of a web that has been cross-machine direction perforate embossed by embossing rolls using pre-heat treated gears. FIGS. 22 and 23 show the amount of drift between adjacent elements for one revolution of the embossing roll set. FIG. 22 depicts the closest clearance between the elements while FIG. 23 depicts the furthest clearance between the elements. Comparing FIGS. 22 and 23, the difference between the closest and furthest clearances between the elements is minor, thereby reflecting a minor circumferential drift in alignment between the embossing rolls. Accordingly, it is evident that precision gearing reduces the circumferential alignment drift between the embossing rolls.

[0111] Those of ordinary skill in the art will be able to determine the acceptable amount of embossing roll circumferential alignment drift. In particular, embossing roll circumferential alignment drift should be minimized to avoid interference between the adjacent engaging elements and to minimize nonuniformity of the perforate embossed web. In addition, those of ordinary skill in the art will understand that the current invention is applicable to other applications, such as perforate embossing operations having elements in both the machine and cross-machine directions.

[0112] In another embodiment of the present invention, at least one of the embossing rolls is crowned. A caliper profile may exist when perforating a web in the cross-machine direction. In particular, when perforating a web in the cross-machine direction at operating speeds, in some instances the caliper of the perforated web near the ends of the embossing rolls may be greater than that at the middle of the roll. This caliper profile indicates that a higher degree of perforation was accomplished near the ends of the embossing rolls. In theory, it is believed that this profile is a function of the speed of the web as it is perforated.

[0113] To test this theory, an experiment was conducted. In the experiment, caliper profiles for a cross-machine direction perforated product were collected. In particular, a web was embossed at both a low running speed and a high, operating speed. The embossing elements were in half-step alignment. Seven caliper readings, data points 1 - 7, were taken across the width of each perforated web. Data points 1 and 7 were located at the opposite ends of the cross-machine direction width of the web, while points 2-6 were located therebetween. To determine the magnitude of a caliper profile, the following formula was used: $\Delta C = \text{avg. caliper (1 & 7)} - \text{avg. caliper (2 - 6)}$. The following data was collected.

Table 14

TRIAL	RUN SPEED (FPM)	ΔC (MILS)
1	454	2.7
	103	0.7
2	436	8.7
	98	1.5
3	516	7.6
	100	4.3
4	480	6.2
	100	-2.0

[0114] As indicated above, for each of the trials the caliper profile, i.e., the difference in caliper between the end portions of the web versus the middle of the web, was more pronounced when the web was perforated at high, oper-

ational, speeds. In particular, when operating at higher, operational speeds the average Δ_c was 6.3. When operating at lower speeds, on the other hand, the average Δ_c was 1.1. In theory, it is believed that the caliper profile exists because the embossing rolls flex when the web is embossed at operational speeds. It is further believed that the profile exists because, while the ends of the rolls are fixed at the bearings, the middle of the roll is free to flex, thus resulting in a caliper profile. That is, the middle of the roll is allowed to flex away from the web and, thus, does not emboss the middle portion of the web at the same level as the ends of the roll.

[0115] When it is desired to reduce the caliper profile, a crowned embossing roll may be used. In one embodiment, only one embossing roll of the embossing roll set is crowned. In another embodiment, both embossing rolls of an embossing roll set are crowned. An embossing roll for use according to the present invention may be from about 6 inches to about 150 inches in width. The average diameter of the embossing roll for use with this invention may be from about 2.5 inches to at least about 20 inches. Selection of the appropriate diameter and width of the embossing roll would be apparent to the skilled artisan based upon a variety of factors, including the width of the web to be embossed and the specifics of the converting machine being used.

[0116] In one embodiment, an embossing roll is provided wherein the diameter of the center portion is greater than that of the ends. That is, the roll is crowned by reducing the diameter of a portion of the embossing roll. In particular, the diameter of the embossing roll is gradually reduced when moving from the center portion of the embossing roll towards the ends of the embossing roll. In one embodiment the reduction towards the ends of the roll being greater such that the shape of the crown is generally parabolic. The diameter of the embossing roll may be decreased at the ends from about 1 - 8 mils. In one embodiment, using an embossing roll having a 10 inch diameter and a 69 inch width, the diametrical crown at the end of the roll is about -2 mils, i.e., the diameter of the ends of the roll is 2 mils less than that at the greatest diameter of the roll. In one embodiment, the diametrical crown at the ends of the roll is approximately -2.4. Those of ordinary skill in the art will be able to determine the appropriate diameters of the reduced diameter portions based on a variety of factors, including the desired physical properties of the finished product, the projected speed of the web, the properties of the base sheet being perforate embossed, and the width and diameter and construction of the emboss rolls. In addition, those of ordinary skill in the art will understand that when only one embossing roll is crowned, instead of both embossing rolls, it may be necessary that the crown of the crowned roll be greater.

[0117] In one example of the above embodiment, the two opposing embossing rolls were crowned. The first embossing roll was crowned at a maximum of 4.1 mils and the second embossing roll crowned at a maximum of 3.8 mils. That is, the maximum diameter reductions in the first and second rolls were 4.1 mils and 3.8 mils, respectively. Tables 6 and 7, below, show the crown dimensions of each of the rolls. The rolls had an embossed face length of 69". The reference points were measured in approximately 5" intervals. The reference point distance is the distance from the reference point to the journal end of the roll. At the center point of the roll, approximately 35" from the journal end, the crown is "0" as that is the largest diameter. The crown, or difference in diameter between the center point and the reference point, is shown in negative numbers to indicate that the diameter at that point is less than the center point diameter. As indicated, the diameter of the roll decreases gradually as the distance from the center increases.

Table 6--

Roll 1			
	Reference Point (inches)	Diameter of Embossing Roll (inches)	Crown (mils)
40	1	10.0251	-4.1
45	5	10.0262	-3.0
50	10	10.0273	-1.9
55	15	10.0276	-1.6
	20	10.0281	-1.1
	25	10.0284	-0.8
	30	10.0292	0.0
	35	10.0292	0.0
	40	10.0292	0.0
	45	10.0290	-0.2
	50	10.0281	-1.1
	55	10.0277	-1.5

Table 6-- (continued)

Roll 1			
Reference Point (inches)	Diameter of Embossing Roll (inches)	Crown (mils)	
60	10.0274	-1.8	
65	10.0265	-2.7	
68	10.0255	-3.7	

10

Table 7--

Roll 2			
Reference Point (inches)	Diameter of Embossing Roll (inches)	Crown (mils)	
1	10.0253	-3.7	
5	10.0263	-2.7	
10	10.0272	-1.8	
15	10.0280	-1.0	
20	10.0285	-0.5	
25	10.0288	-0.2	
30	10.0288	-0.2	
35	10.0290	0.0	
40	10.0290	0.0	
45	10.0285	-0.5	
50	10.0282	-0.8	
55	10.0277	-1.3	
60	10.0271	-1.9	
65	10.0262	-2.8	
68	10.0252	-3.8	

[0118] Of note, the above measurements were taken prior to the crowned roll being chromed. According to one embodiment, the embossing rolls can be plated with chrome. Chrome plating provides added durability, increased releasability of the web, and corrosion resistance to the embossing rolls. Copending U.S. Patent Application No. 10/187,608, which is incorporated herein by reference, discusses, *inter alia*, wear resistant coating for embossing rolls. After the rolls were chromed, reference points 1 and 68 of the first roll measured -3.7 mils and -3.3 mils, respectively, while reference points 1 and 68 of the second roll measured -3.5 mils and -3.5 mils, respectively.

[0119] To determine the effect of the crowned rolls on the caliper profile of the perforate embossed web, a trial was conducted using the crowned rolls. During the trial, paper webs were perforate embossed at an average speed of 520 feet per minute (the minimum and maximum speeds being 472 and 537 feet per minute, respectively) at both full step alignment and half step alignment. The caliper profile was measured as described above. The average delta, i.e., caliper difference between the ends of the roll compared to the middle portion of the web, was -1.8. In comparison, in a similar trial using non-crowned rolls where the paper webs were perforate embossed in both full step and half step alignment at an average speed of 484 feet per minute (the minimum and maximum speeds being 432 and 555 feet per minute, respectively), the average delta was 4.6. Thus, based on the achieved results, crowning the rolls has the effect of reducing the caliper profile of the perforate embossed web.

[0120] Those of ordinary skill in the art will understand that various caliper profiles can be achieved by changing the crown profile of the embossing rolls. For example, in the previously discussed example, the caliper profile of the web perforate embossed using non-crowned rolls had a positive profile of 4.6 (i.e., the caliper of the perforated web near the ends of the embossing rolls was greater than that at the middle of the roll). When the described crowned rolls were

used, the caliper profile of the web was slightly negative at -1.8, indicating that the caliper of the perforated web near the ends of the embossing rolls was less than that at the middle of the roll. Thus, one of ordinary skill in the art would readily appreciate that a caliper profile of approximately zero could be attained by crowning the rolls by less than the above-described rolls. For example, the rolls could be crowned by approximately 2-3 mils.

5 [0121] Those of ordinary skill in the art will understand that the crowning technique is applicable to other applications, but our experience suggests that it is particularly useful with patterns having substantial numbers of perforate embossing elements in the cross-machine direction.

[0122] In yet another embodiment of the present invention, an alignment means is provided for the embossing rolls. In one embodiment, an adjustable collar ring is provided on the first embossing roll. The second embossing roll may 10 have an adjustable collar ring, a fixed collar, a machined keyway, or other means for identifying a particular position of the second embossing roll. In another embodiment of the present invention, scribe marks are provided on each of the first and second embossing rolls.

[0123] In one embodiment an adjustable collar ring is provided on an end of each of the matched embossing rolls. FIG. 24 depicts a collar for use with the present invention. The collar 70 includes a plurality of slots 72 capable of 15 receiving fastening means (not shown) for attaching the collar 70 to an end of the embossing roll. The collar 70 should have at least two slots 72. Those of ordinary skill in the art will understand that more than two slots can be included in the collar. The collar 70 depicted in FIG. 24 has four slots. The collar 70 further includes a keyway 74. The keyway 74 provides the capability of aligning the embossing roll with a second embossing roll having a keyway 74. The collar 70 can be made of various materials, including stainless steel, carbon steel, iron, or other appropriate material known by 20 those of ordinary skill in the art, or later discovered, to be suitable for use as a collar for a roll in a paper making machine.

[0124] An alignment process for a first and second embossing roll having first and second adjustable collar rings will now be discussed. In one embodiment of an embossing operation having first and second embossing rolls, each embossing roll will have a collar on one common end. The initial alignment of the embossing rolls is as follows. First, the operator brings the rolls into close proximity, without allowing contact between the cross-machine embossing elements. A web, such as a nip impression paper, is then fed through the embossing roll, leaving an imprint of the location of the elements on the nip impression paper. The imprinted web is then analyzed to determine whether the elements will contact each other when the embossing rolls are brought into closer proximity. Based on the outcome of the imprint, the machine direction alignment of the embossing rolls may be adjusted. After any necessary adjustment, the rolls are brought into closer proximity and a web is once again fed through the embossing rolls to determine the location of the 25 elements. This process is repeated until the embossing rolls, and hence the embossing elements, are in operating engagement position. Once the embossing rolls are in position, the collars are aligned such that the keyways face each other. A key (not shown) is then placed in the opposing keyways to fix the alignment of the collars. The fastening means are then tightened, thereby setting the collars in place. In one embodiment, the adjusted collar is pinned into place to prevent adjustment of the collar after the initial setting.

[0125] For subsequent alignment of the embossing rolls, for example, after one or both rolls are removed for maintenance purposes, or the circumferential alignment of either of the rolls is changed for any reason, the rolls are brought into close proximity, the embossing rolls are maneuvered such that the keyways of the opposing collars are facing each other, the key is inserted into the keyways, and then the embossing rolls are brought into engagement. Because the embossing rolls have previously been aligned, the embossing rolls can be brought into engagement without substantial risk of interference of the cross-machine elements. After the embossing rolls are brought into engagement, fine adjustments can then be made. Using the present invention, the required time to align the embossing rolls to 0.000" engagement after the initial alignment is reduced to approximately one hour or less. The initial alignment of the embossing rolls, described above, can be accomplished either at the fabrication facility or while the rolls are on the paper converting machine. Those of ordinary skill in the art will understand that keying is applicable to other applications, 30 but we have found that it is particular useful for this application wherein perforate embossing elements extend in the cross-machine direction.

[0126] This invention can be used in a variety of different processes. The webs in each of the above-described examples were formed in a conventional wet press process. However, the invention is equally applicable when the base web is a through air dried web. In addition, to increase the smoothness of the resulting product, the web may be 35 calendered. Or, as in one of the examples above, to increase the bulkiness of the product, an undulatory creping blade such as described in U.S. Patent No. 5,690,788, which is herein incorporated by reference, may be used. Those of ordinary skill in the art will understand the variety of processes in which the above-described invention can be employed.

[0127] It is understood that the invention is not confined to the particular construction and arrangement of parts and the particular processes described herein but embraces such modified forms thereof as come within the scope of the 40 following claims.

Claims

1. An embossing system for embossing and perforating at least a portion of a web comprising:
 - 5 a first embossing roll having embossing elements; and
at least a second embossing roll having embossing elements, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web; and
wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction.
- 10 2. An embossing system for embossing at least a portion of a web comprising:
 - 15 a first embossing roll; and
at least a second embossing roll,
wherein each of the first and second embossing rolls has at least one juxtaposable embossing element substantially oriented in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web, and
wherein at least a substantial portion of the cross-machine direction elements have at least the ends beveled.
- 20 3. The embossing system of claim 1 wherein substantially all of the perforate nips are substantially oriented in the cross-machine direction.
- 25 4. The embossing system of claim 1 wherein all of the perforate nips are substantially oriented in the cross-machine direction.
5. The embossing system of claim 1 or claim 2, wherein at least a portion of the embossing elements are male elements that are substantially oval shaped.
- 30 6. The embossing system of claim 1 or claim 2, wherein at least a portion of the embossing elements are male elements that are substantially hexagonal shaped.
7. The embossing system of claim 1 or claim 2, wherein at least a portion of the embossing elements are male elements that are substantially rectangular shaped.
- 35 8. The embossing system of claim 1 or claim 2, wherein at least a portion of the cross-machine embossing elements are male elements having a height of at least about 15 mils.
9. The embossing system of claim 8 wherein at least a portion of the cross-machine embossing elements are male elements having a height of at least about 30 mils.
- 40 10. The embossing system of claim 9 wherein at least a portion of the cross-machine embossing elements are male elements having a height of at least from about 30 to 65 mils.
11. The embossing system of claim 8 wherein at least a portion of the cross-machine embossing elements are male elements having a height of at least about 45 mils.
- 45 12. The embossing system of claim 8 wherein at least a portion of the cross-machine embossing elements are male elements having a height of at least about 60 mils.
- 50 13. The embossing system of claim 1 or claim 2 wherein the cross-machine embossing elements have angled side-walls, wherein the sidewalls have an angle of less than about 20°.
14. The embossing system of claim 1 or claim 2 wherein the sidewall angle of the cross-machine direction elements is less than about 11°.
- 55 15. An embossing system for embossing and perforating at least a portion of a web comprising:

a first embossing roll; and
at least a second embossing roll,

5 wherein each of the first and second embossing rolls has at least one juxtaposable embossing element defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web, and

wherein at least a substantial portion of the cross-machine direction elements have sidewall angles of less than about 20°.

- 10 16. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine direction elements have sidewall angles of less than about 17°.
17. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine direction elements have sidewall angles of less than about 14°.
- 15 18. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine direction elements have sidewall angles of from about 7° to 11°.
19. The embossing system of claim 15 wherein the embossing elements are substantially oval shaped.
20. The embossing system of claim 15 wherein the embossing elements are substantially hexagonal shaped.
21. The embossing system of claim 15 wherein the embossing elements are substantially rectangular shaped.
- 25 22. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine embossing elements are at an angle of from at least about 60° to 120° from the machine direction.
23. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine embossing elements are at an angle of about 85° to 95° from the machine direction.
- 30 24. The embossing system of claim 15 wherein the height of the cross-machine embossing elements is from at least about 15 mils.
- 25 25. The embossing system of claim 15 wherein the height of the cross-machine embossing elements is from at least about 30 mils.
26. The embossing system of claim 15 wherein the height of the cross-machine embossing elements is from about 30 to 65 mils.
- 40 27. The embossing system of claim 15 wherein the height of the cross-machine embossing elements is at least from about 45 mils.
28. The embossing system of claim 15 wherein the height of the cross-machine embossing elements is at least from about 60 mils.
- 45 29. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine embossing elements are in full-step alignment.
30. The embossing system of any one of claims 1, 2 or 15, wherein the cross-machine embossing elements are in half-step alignment.
31. The embossing system of claim 48 wherein the cross-machine embossing elements are in quarter-step alignment.
- 55 32. The embossing system of any one of claims 1, 2 or 15, having a cross-machine element engagement of from greater than about 15 mils.
33. The embossing system of any one of claims 1, 2 or 15, having a cross-machine element engagement of at least about 16 to 32 mils.

34. The embossing system of any one of claims 1, 2 or 15, wherein at least a portion of the elements have a height of at least about 30 mils and have an engagement of at least about 15 mils.
- 5 35. The embossing system of any one of claims 1, 2 or 15, wherein at least a portion of the elements have a height of at least about 30 mils and have an engagement of at least about 24 mils.
- 10 36. A method for embossing and perforating at least a portion of a web comprising:
 providing a first embossing roll having embossing elements; and
 providing at least a second embossing roll having embossing elements,
 wherein at least a predominate number of the embossing elements are substantially oriented in the cross-machine direction and wherein the first and second embossing rolls define a perforate nip for embossing and perforating the web; and
15 passing the web between the first and second rolls wherein the first and second embossing rolls are configured and the engagement and alignment therebetween are controlled to result in an element clearance that will achieve a non-picking clearance while achieving at least a 15% reduction in the machine direction tensile strength of the web.
- 20 37. The method of claim 36 wherein the embossing elements are substantially oval shaped.
38. The method of claim 36 wherein the embossing elements are substantially hexagonal shaped.
39. The method of claim 36 wherein the embossing elements are substantially rectangular shaped.
25 40. The method of claim 36 wherein the cross-machine embossing elements are at an angle of from about at least 60° to 120° from the machine direction.
- 30 41. The method of claim 36 wherein the cross-machine embossing elements are at an angle off about 85° to 95° from the machine direction.
42. The method of claim 36 wherein the height of the cross-machine embossing elements is from at least about 15 mils.
43. The method of claim 36 wherein the height of the cross-machine embossing elements is from at least about 30 mils.
35 44. The method of claim 36 wherein the height of the cross-machine embossing elements is from about 30 to 65 mils.
- 45 45. The method of claim 36 wherein the height of the cross-machine embossing elements is at least from about 45 mils.
46. The method of claim 36 wherein the height of the cross-machine embossing elements is at least from about 60 mils.
40 47. The method of claim 36 wherein the cross-machine embossing elements are in full-step alignment.
48. The method of claim 36 wherein the cross-machine embossing elements are in half-step alignment.
45 49. The method of claim 36 wherein the cross-machine embossing elements are in quarter-step alignment.
- 50 50. The method of claim 36 having a cross-machine element engagement of from at least about 15 mils.
51. The method of claim 36 having a cross-machine element engagement of from about 16 to 32 mils.
50 52. The method of claim 36 wherein the cross-machine embossing elements have angled sidewalls, wherein the sidewalls have an angle of less than about 20°.
- 55 53. The method of claim 36 wherein the sidewall angle of the cross-machine elements is less than about 17°.
54. The method of claim 36 wherein the sidewall angle of the cross-machine elements is less than about 14°.

55. The method of claim 36 wherein the sidewall angle of the cross-machine elements is less than about 11°.
56. The method of claim 36 wherein the sidewall angle of the cross-machine embossing elements is from about 7° to 11°.
- 5 57. A method for reducing the tensile ratio of a web by embossing and perforating the web comprising:

10 passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web; and

15 wherein at least a predominant number of the perforate nips are substantially oriented in the cross-machine direction.

- 15 58. The method of claim 57 wherein the tensile ratio of the web is reduced by at least 10% of the difference between the base web tensile ratio and 1.
- 20 59. The method of claim 57 wherein the tensile ratio of the web is reduced by at least 20% of the difference between the base web tensile ratio and 1.
60. The method of claim 57 wherein the tensile ratio of the web is reduced by at least 30% of the difference between the base web tensile ratio and 1.
- 25 61. The method of claim 57 wherein substantially all of the perforate nips are substantially oriented in the cross-machine direction.
62. The method of claim 57 wherein all of the perforate nips are substantially oriented in the cross-machine direction.

- 30 63. A method for reducing the tensile ratio of a web by embossing and perforating the web comprising:

35 passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having at least one embossing element oriented substantially in the cross-machine direction and at least a second embossing roll having at least one juxtaposable embossing element oriented substantially in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web; and

wherein at least a substantial portion of the cross-machine direction elements have at least the ends beveled.

- 40 64. A method for reducing the tensile ratio of a web by embossing and perforating the web comprising:

45 passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having at least one embossing element oriented substantially in the cross-machine direction and at least a second embossing roll having at least one embossing element oriented substantially in the cross-machine direction, thereby defining a cross-machine direction perforate nip between the cross-machine direction elements for embossing and perforating the web; and

50 wherein at least a portion of the cross-machine direction elements have cross-machine direction sidewall angles of less than about 20°.

- 50 65. A method for reducing the tensile ratio of a web by embossing and perforating the web comprising:

55 passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a perforate nip extending in the cross machine direction for embossing and perforating the web; and

wherein the first and second embossing rolls are configured to, and the engagement and alignment are

controlled to, result in an element clearance that will achieve a non-picking clearance.

- 66. The method of claim 36, 57, 63, 64, or 65, wherein the web is a creped web.
- 5 67. The method of claim 66 wherein the web is creped with an undulatory creping blade.
- 68. The method of claim 36, 57, 63, 64, or 65 wherein the web is calendered.
- 10 69. A perforate embossed web having a plurality of cross-machine direction oriented perforations wherein the embossed web has a tensile ratio of less than about 1.2.
- 70. A perforate embossed web having a transluminance ratio of at least 1.005.
- 15 71. The perforate embossed web of claim 70 having a transluminance ratio of at least 1.01.
- 72. A wet-laid cellulosic perforate embossed web having perforate embossments extending predominately in the cross-machine direction.
- 20 73. The wet-laid cellulosic perforate embossed web having perforate embossments extending predominately in the cross-machine direction of claim 72 wherein the perforate embossments extend in the cross-machine direction for at least about 20 mils.
- 74. The wet-laid cellulosic perforate embossed web having perforate embossments extending predominately in the cross-machine direction of claim 72 wherein the angle between the perforate embossments extending in the cross-machine direction and the machine direction of the web is between 60° and 120°.
- 25 75. The wet-laid cellulosic perforate embossed web having perforate embossments extending predominately in the cross-machine direction of claim 72 wherein said perforate embossments extend substantially through the thickness of the web.
- 30 76. The wet-laid cellulosic perforate embossed web according to claim 70 having a transluminance ratio of at least 1.02.
- 77. A method of embossing and perforating the web comprising:
 - 35 passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web; and
 - 40 wherein the tensile ratio of the web is reduced by at least about 5% of the difference between the tensile ratio of the base sheet and 1.0.
 - 78. The embossing system of any one of claims 1, 2, or 15 wherein at least a first portion of the cross-machine embossing elements are male elements having a height of at least about 15 mils and wherein at least a second portion of the cross-machine embossing elements are male elements having a height of at least about 15 mils and wherein the height of the second portion elements is greater than that of the first portion elements.
 - 45 79. An embossing system for perforate embossing at least a portion of a web comprising:
 - 50 a first embossing roll having embossing elements; and
at least a second embossing roll having embossing elements, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web,
 - 55 wherein at least a portion of at least the first or second embossing roll is crowned, and
wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction.
 - 80. The embossing system according to claim 79 wherein at least a portion of each of the first and second embossing rolls is crowned.

81. The embossing system according to claim 79 wherein the crown of the embossing roll is substantially parabolic in shape.
82. The embossing system according to claim 79 wherein the crown is at least approximately 1 mil.
- 5 83. The embossing system according to claim 79 wherein the crown is at least approximately 2 mils.
84. The embossing system according to claim 79 wherein the crown is at least approximately 3 mils.
- 10 85. The embossing system according to claim 79 wherein the crown is at least approximately 5 mils.
86. A perforate embossing roll having embossing elements wherein at least a majority of the embossing elements are substantially oriented in the cross-machine direction and wherein the embossing roll is crowned.
- 15 87. The perforate embossing roll according to claim 86 wherein the crown of the embossing roll is substantially parabolic in shape.
88. The perforate embossing roll according to claim 86 wherein substantially all of the embossing elements are substantially oriented in the cross-machine direction.
- 20 89. An embossing system for perforate embossing at least a portion of a web comprising:
 - a first embossing roll having embossing elements, the first embossing roll being in communication with a first gear; and
 - 25 at least a second embossing roll having embossing elements, the second embossing roll being in communication with a second gear, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web; and
 - wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction, and
 - 30 wherein the first gear and the second gear have a precision rating of greater than Q-6.
90. The embossing system according to claim 89 further including a precision hub.
91. The embossing system of claim 89 wherein the first gear and the second gear have a precision rating of at least about Q-8.
- 35 92. The embossing system of claim 89 wherein the first gear and the second gear have a precision rating of at least about Q-10.
93. The embossing system of claim 89 wherein the first gear and the second gear are pre-heat treated gears.
- 40 94. The embossing system of claim 89 wherein the first gear and the second gear are hobbed gears.
95. The embossing system of claim 89 wherein the first gear and the second gear are ground gears.
- 45 96. The embossing system according to claim 89 wherein the first gear and the second gear are shaved gears.
97. An embossing system for perforate embossing at least a portion of a web comprising:
 - 50 a first embossing roll having embossing elements, the first embossing roll having a first alignment means; and at least a second embossing roll having embossing elements, the second embossing roll having a second alignment means,
 - wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web and
 - 55 wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction.
98. The embossing system of claim 97 wherein at least the first or second alignment means includes a collar having

a keyway.

99. The embossing system of claim 97 wherein the first alignment means includes an adjustable collar and the second alignment means includes a fixed collar.

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100. The embossing system of claim 97 wherein at least the first or second alignment means includes scribe marks.

101. The embossing system of claim 97 wherein the first and second alignment means include matched keyways.

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102. A perforate embossing roll having embossing elements wherein at least a majority of the embossing elements are substantially oriented in the cross-machine direction and wherein the embossing roll has an alignment means.

103. The perforate embossing roll according to claim 102 wherein substantially all of the embossing elements are substantially oriented in the cross-machine direction.

15

104. A method of engaging at least two perforate embossing rolls comprising:

providing a first embossing roll having at least a portion of the embossing elements substantially oriented in the cross-machine direction, the embossing roll having a first collar, and the first collar having a first keyway;

20 providing at least a second embossing roll having at least a portion of the embossing elements substantially oriented in the cross-machine direction, the embossing roll having a second collar, and the second collar having a second keyway;

bringing the first and second embossing rolls into close proximity;

aligning the first and second keyways; and

25

bringing the first and second embossing rolls into engagement.

105. The method according to claim 104 wherein at least the first or second collar is an adjustable collar ring.

106. A method for perforate embossing at least a portion of a web comprising:

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providing a first embossing roll having embossing elements; and

providing at least a second embossing roll having embossing elements,

35 wherein at least a portion of at least the first or second embossing roll is crowned, and wherein at least a predominate number of the embossing elements of the first and second embossing rolls are substantially oriented in the cross-machine direction, and wherein the first and second embossing rolls define a perforate nip for perforate embossing the web; and

40 passing the web between the first and second rolls wherein the first and second embossing rolls are configured and the engagement and alignment therebetween are controlled to result in an element clearance that will achieve a non-picking clearance while achieving at least a 15% reduction in the machine direction tensile strength of the web.

107. A method for embossing and perforating at least a portion of a web comprising:

45 providing a first embossing roll having embossing elements, the first embossing roll being in communication with a first gear; and

providing at least a second embossing roll having embossing elements, the second embossing roll being in communication with a second gear,

50 wherein at least a predominate number of the embossing elements are substantially oriented in the cross-machine direction and wherein the first and second embossing rolls define a perforate nip for embossing and perforating the web, and wherein the first gear and the second gear have a precision rating of greater than Q-6; and

55 passing the web between the first and second rolls wherein the first and second embossing rolls are configured and the engagement and alignment therebetween are controlled to result in an element clearance that will achieve a non-picking clearance while achieving at least a 15% reduction in the machine direction tensile strength of the web.

108. A method for perforate embossing a web without increasing the MD/CD tensile ratio of the web comprising:

passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein at least a portion of at least the first or second embossing rolls are crowned, and wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web; and

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wherein at least a predominant number of the perforate nips are substantially oriented in the cross-machine direction.

109.A method for perforate embossing a web without increasing the MD/CD tensile ratio of the web comprising:

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passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and wherein the first embossing roll is in communication with a first gear, and at least a second embossing roll having embossing elements, wherein the second embossing roll is in communication with a second gear, the first and second gears having a precision rating of at least Q-6, and wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web; and

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wherein at least a predominant number of the perforate nips are substantially oriented in the cross-machine direction.

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110.The method according to claim 107 or 108, further including a precision hub.

111.A method of perforate embossing a web comprising:

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passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements and at least a second embossing roll having embossing elements, wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web, and wherein at least a portion of at least the first embossing roll or the second embossing roll is crowned; and

30

wherein the MD/CD tensile ratio of the web is not increased.

112.A method of perforate embossing a web comprising:

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passing a web through an embossing system, wherein the embossing system comprises a first embossing roll having embossing elements, wherein the first embossing roll is in communication with a first gear, and at least a second embossing roll having embossing elements, wherein the second embossing roll is in communication with a second gear, the first and second gears having a precision rating of greater than Q-6, and wherein the first and second embossing rolls define a plurality of perforate nips for embossing and perforating the web; and

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wherein the MD/CD tensile ratio of the web is not increased.

45

113.A perforate embossing roll having embossing elements wherein at least a portion of the embossing elements are substantially oriented in the cross-machine direction, wherein the embossing roll is in communication with a gear, and wherein the gear has a precision rating of greater than Q-6.

114.An embossing system for perforate embossing at least a portion of a web comprising:

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a first embossing roll having embossing elements; and
at least a second embossing roll having embossing elements, wherein the embossing elements of the first and second embossing rolls define perforate nips for embossing and perforating the web,

55

wherein the first and second embossing rolls have an alignment means, and
wherein at least a portion of the perforate nips are substantially oriented in the cross-machine direction.

115.The embossing system of claim 114 wherein the alignment means includes a collar having a keyway.

116.A method of engaging at least two embossing rolls comprising:

providing a first embossing roll having perforate embossing elements substantially oriented in the cross machine direction;
providing at least a second embossing roll having perforate embossing elements substantially oriented in the cross machine direction, the first and second embossing rolls having an alignment means;
5 bringing the first and second embossing rolls into close proximity;
aligning the alignment means; and
bringing the first and second embossing rolls into engagement.

117.The method according to claim 116 wherein the alignment means includes a collar having a keyway.

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118.A method of perforate embossing a web wherein at least a majority of the perforations are substantially oriented in the cross-machine direction and wherein the caliper profile, Δ_{c} , of the web is less than 2.

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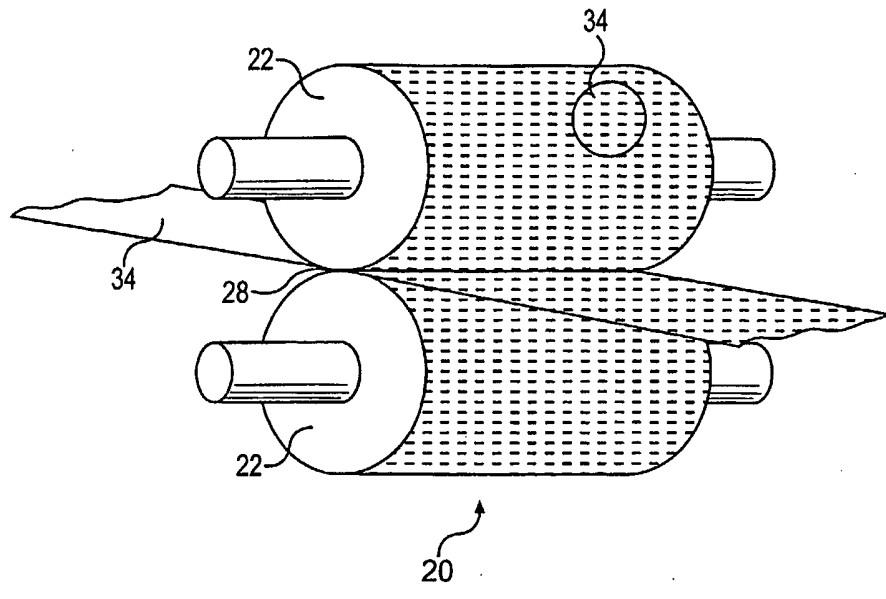
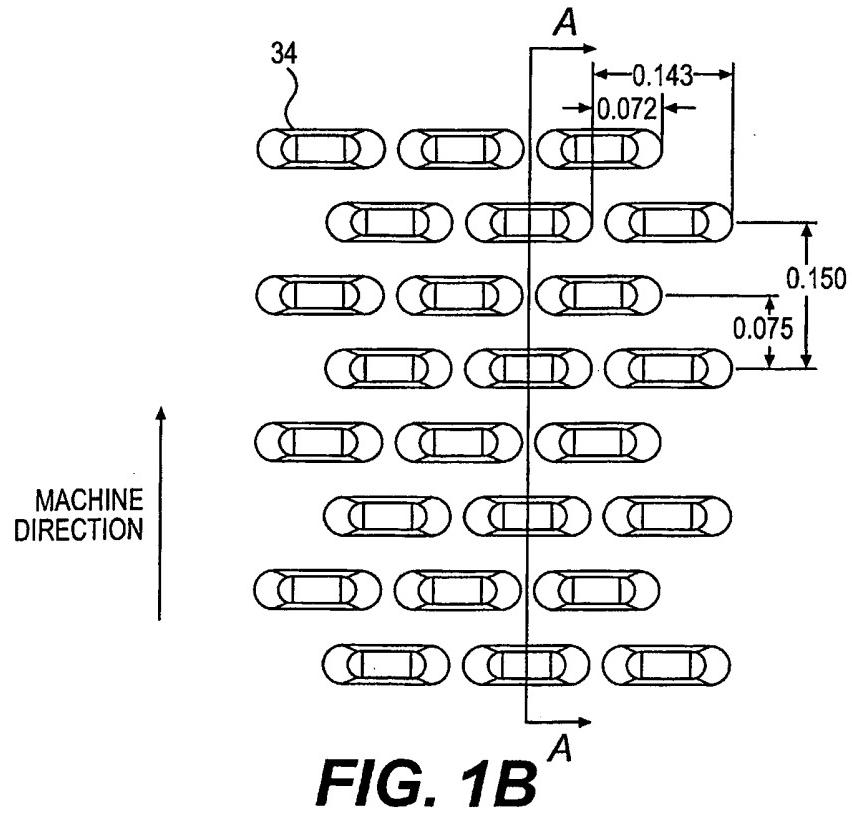
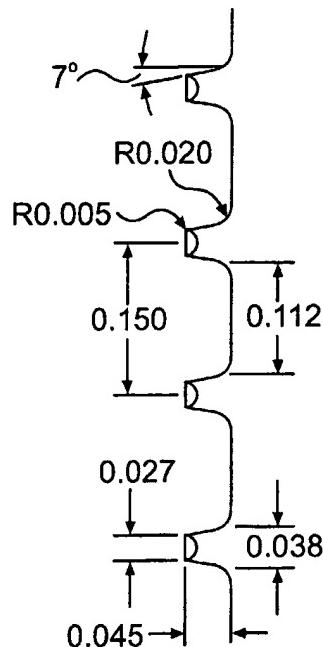


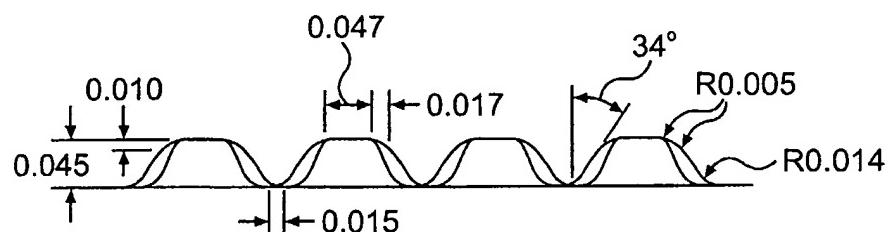
FIG. 1A





SECTION A-A

FIG. 1C



SIDE VIEW

FIG. 1D

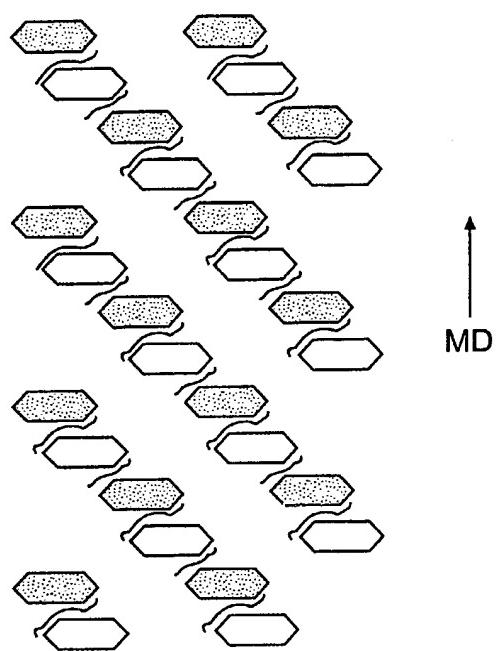


FIG. 2

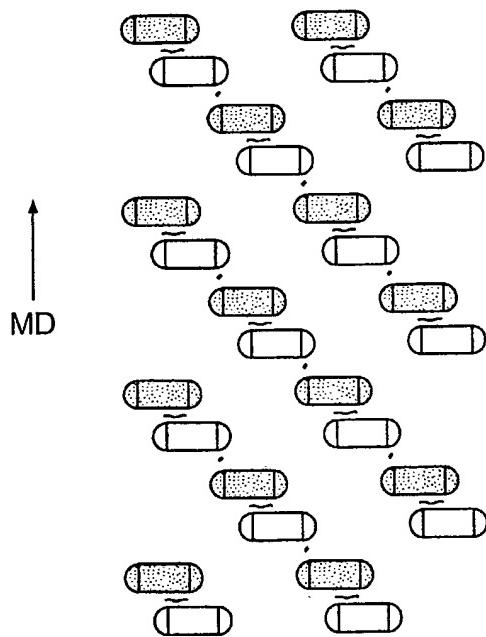


FIG. 3

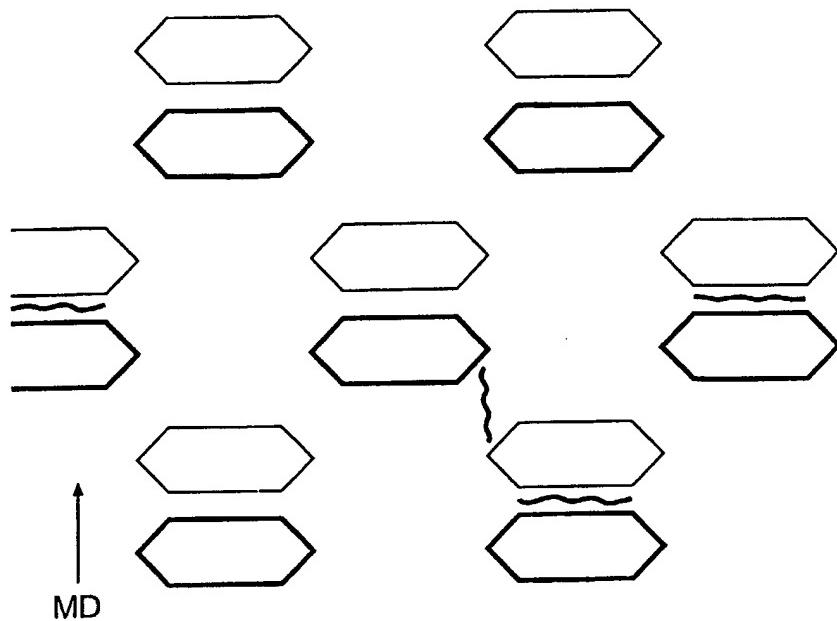


FIG. 4

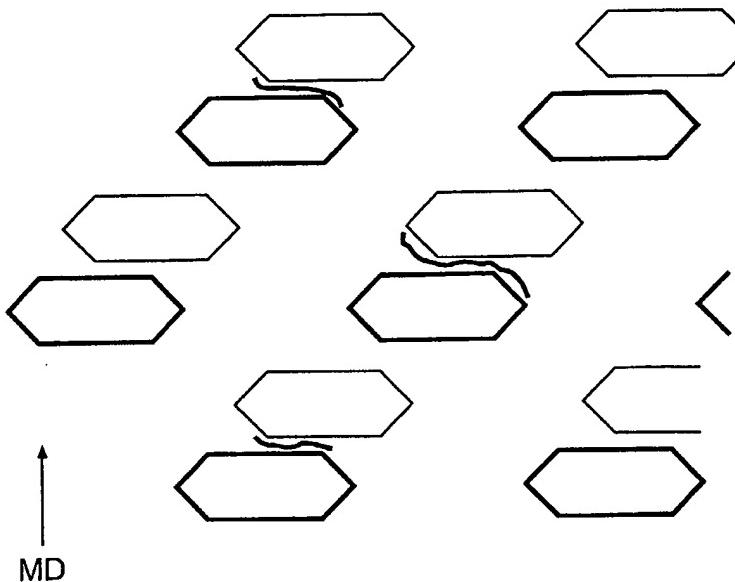


FIG. 5

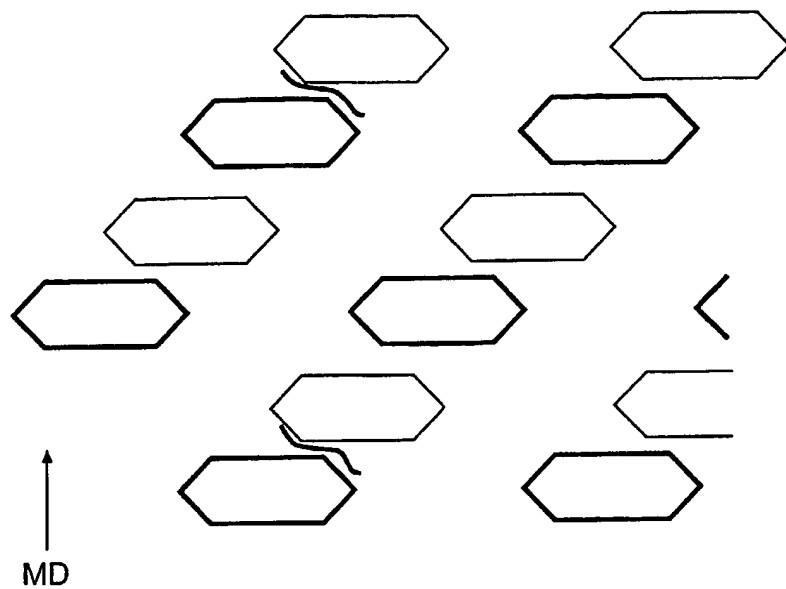


FIG. 6

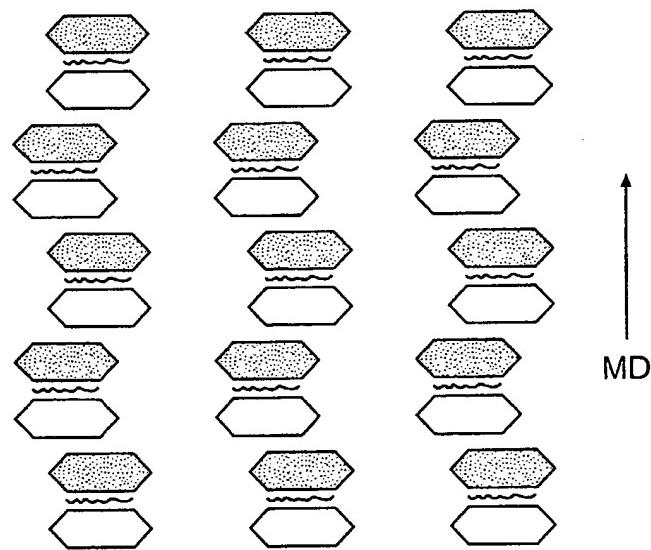


FIG. 7

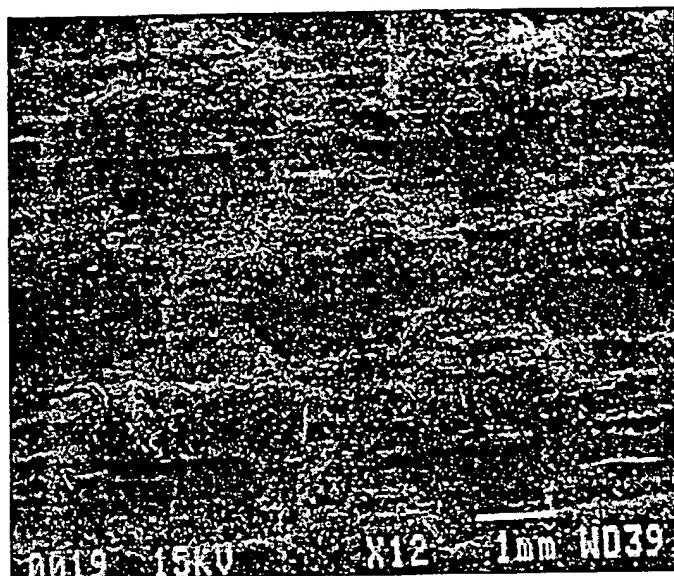


FIG. 8

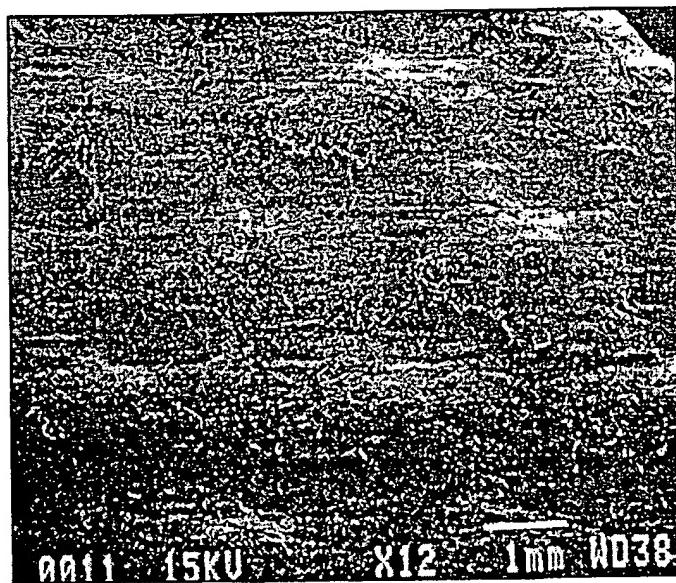


FIG. 9

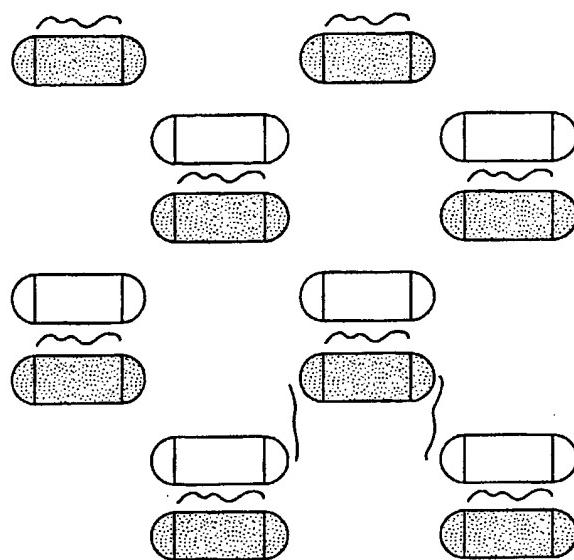


FIG. 10

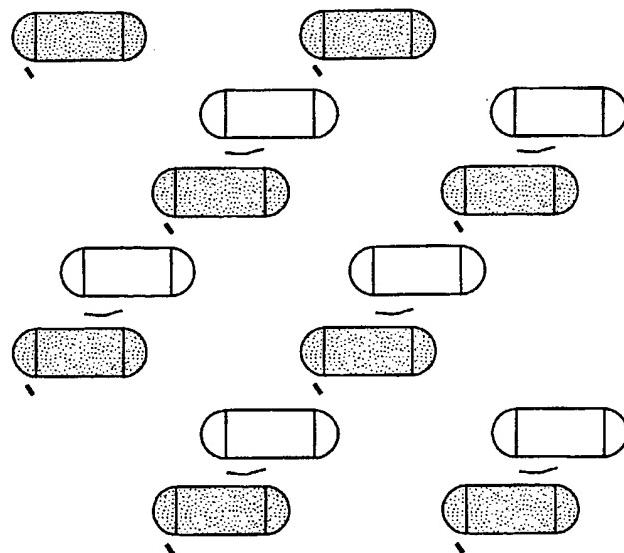


FIG. 11

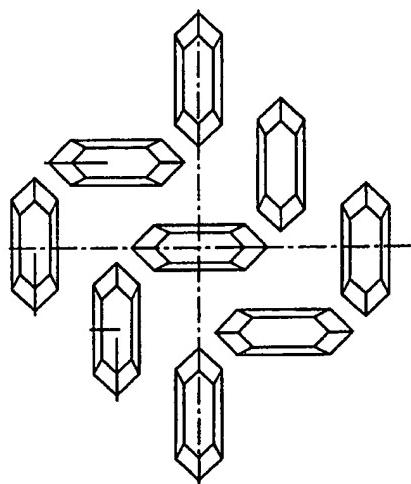


FIG. 16B

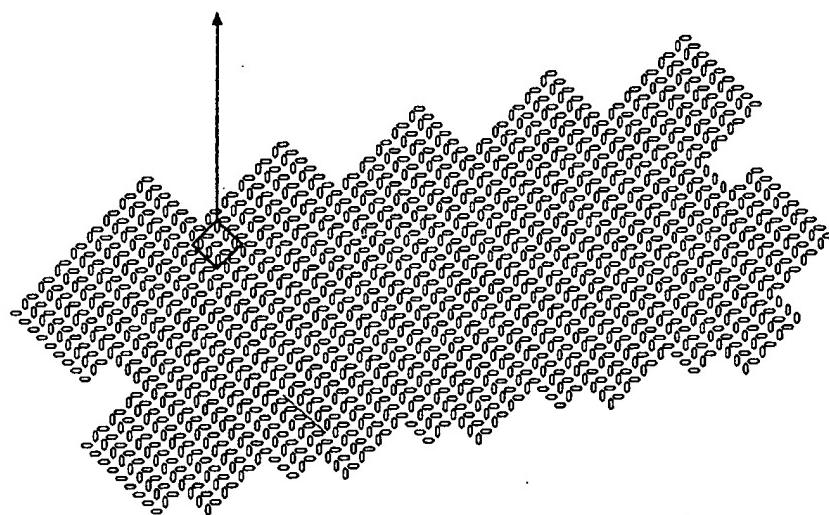
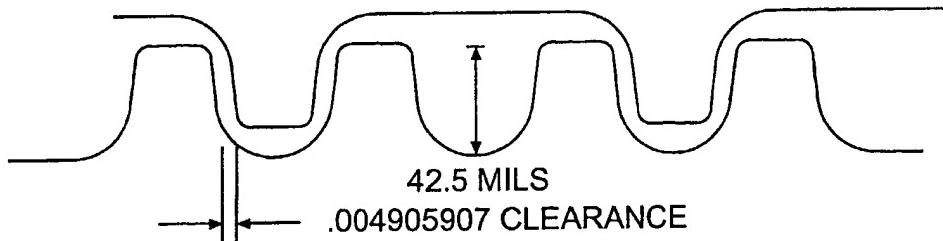


FIG. 16A

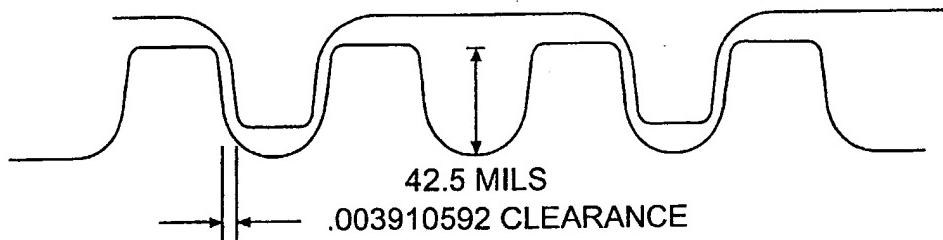
←
MACHINE
DIRECTION

AT .032 ENGAGEMENT



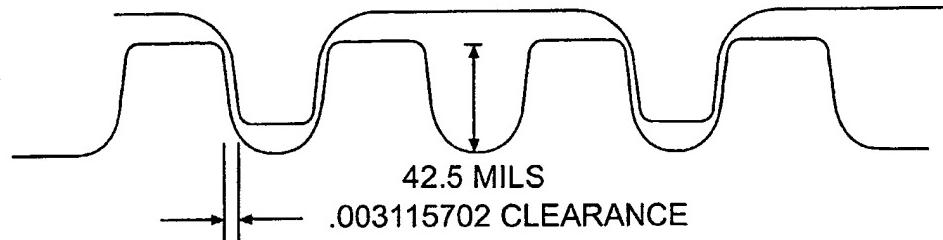
7° WALL ANGLE CENTERED ALIGNMENT

FIG. 12A



9° WALL ANGLE CENTERED ALIGNMENT

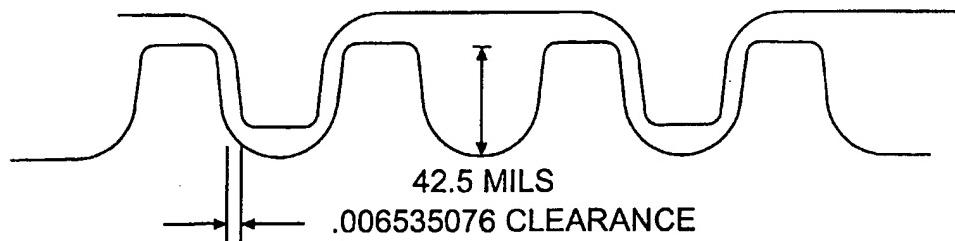
FIG. 12B



11° WALL ANGLE CENTERED ALIGNMENT

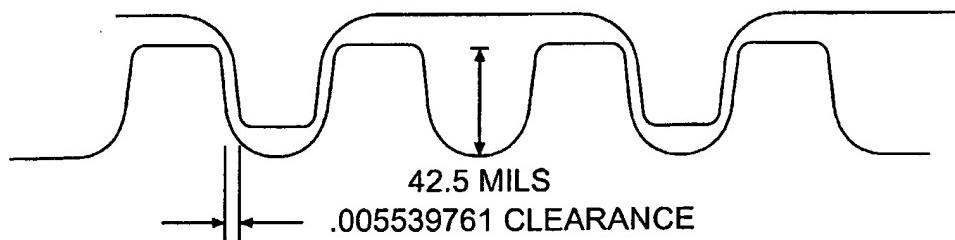
FIG. 12C

AT .028 ENGAGEMENT



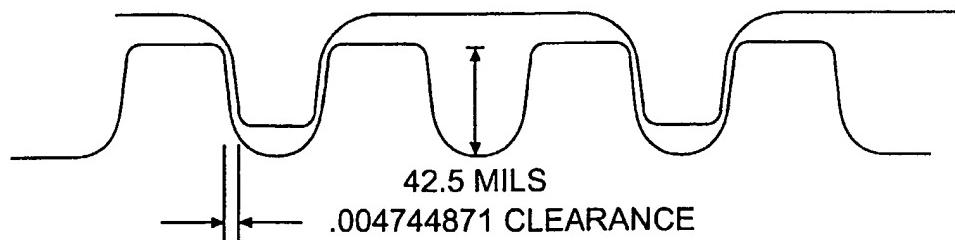
7° WALL ANGLE CENTERED ALIGNMENT

FIG. 13A



9° WALL ANGLE CENTERED ALIGNMENT

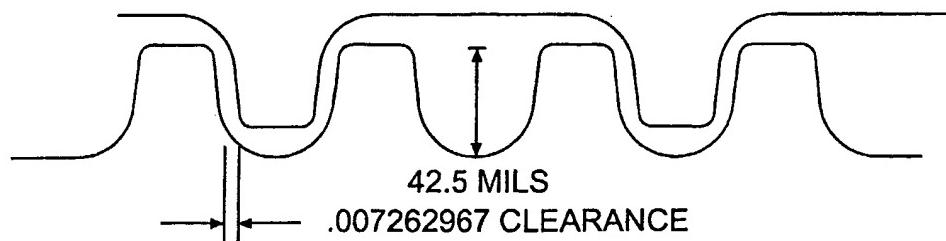
FIG. 13B



11° WALL ANGLE CENTERED ALIGNMENT

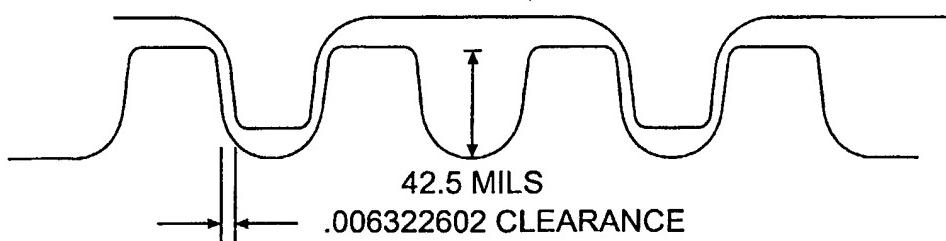
FIG. 13C

AT .024 ENGAGEMENT



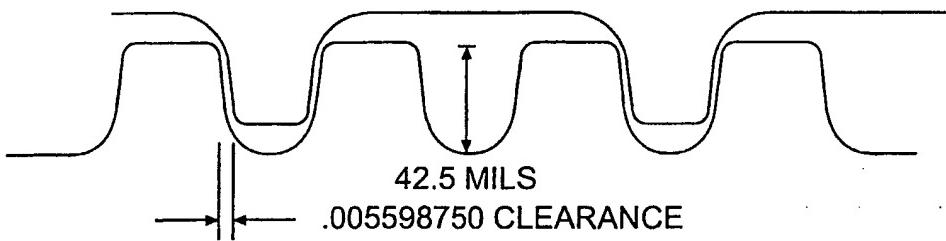
7° WALL ANGLE CENTERED ALIGNMENT

FIG. 14A



9° WALL ANGLE CENTERED ALIGNMENT

FIG. 14B



11° WALL ANGLE CENTERED ALIGNMENT

FIG. 14C

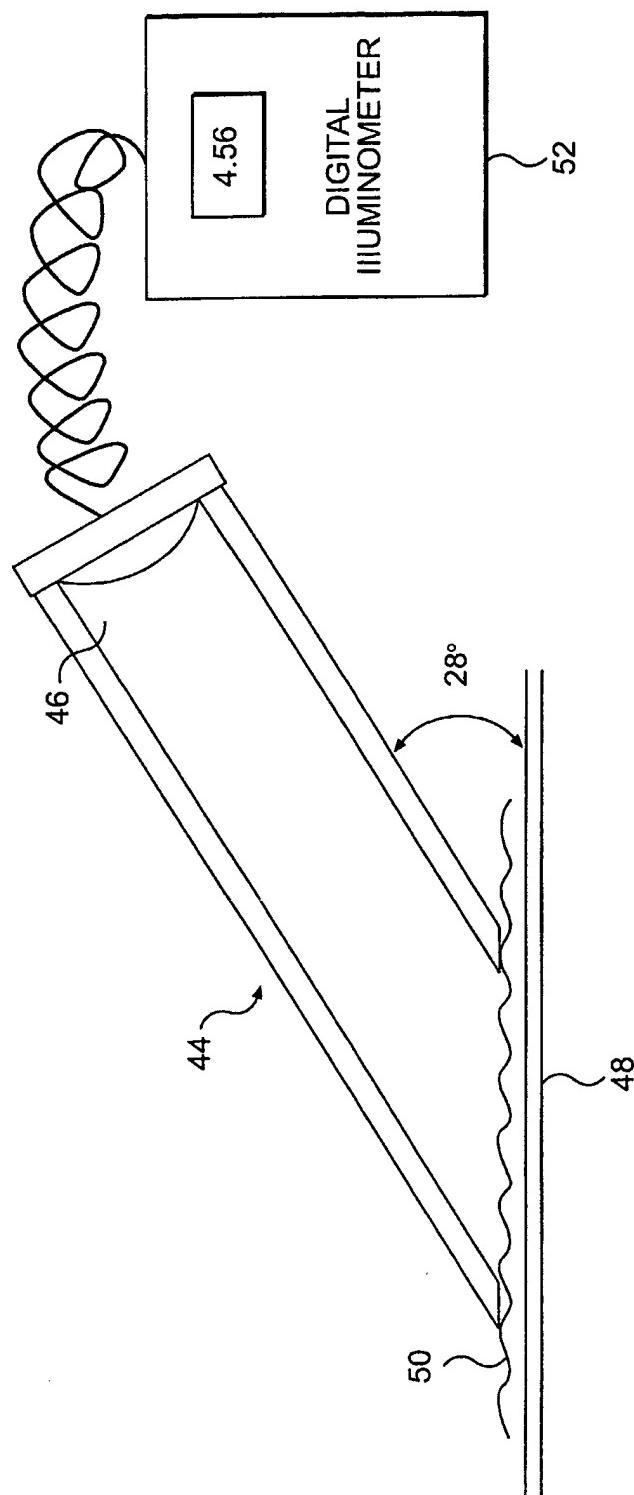


FIG. 15

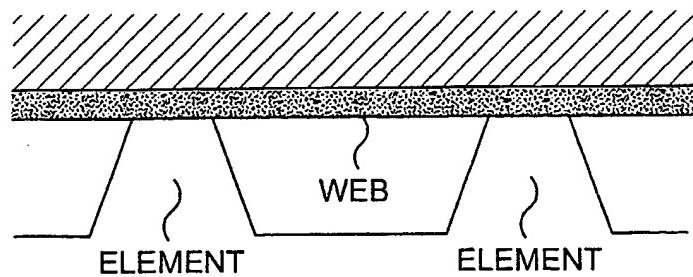


FIG. 17A

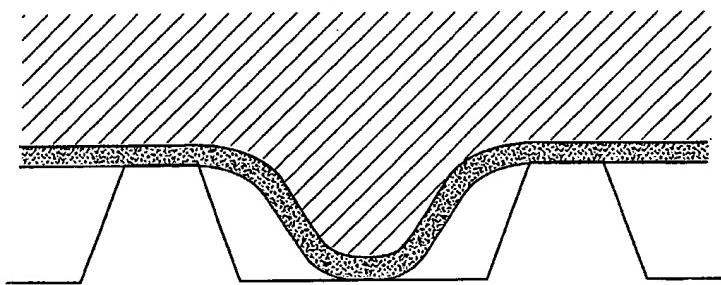


FIG. 17B

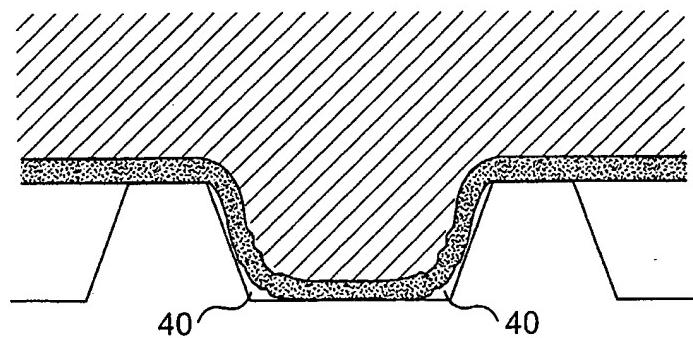


FIG. 17C

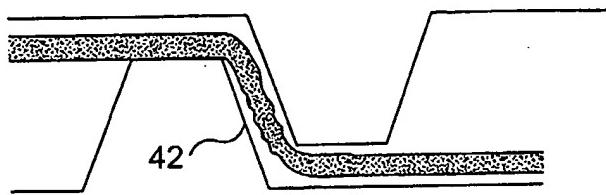


FIG. 17D

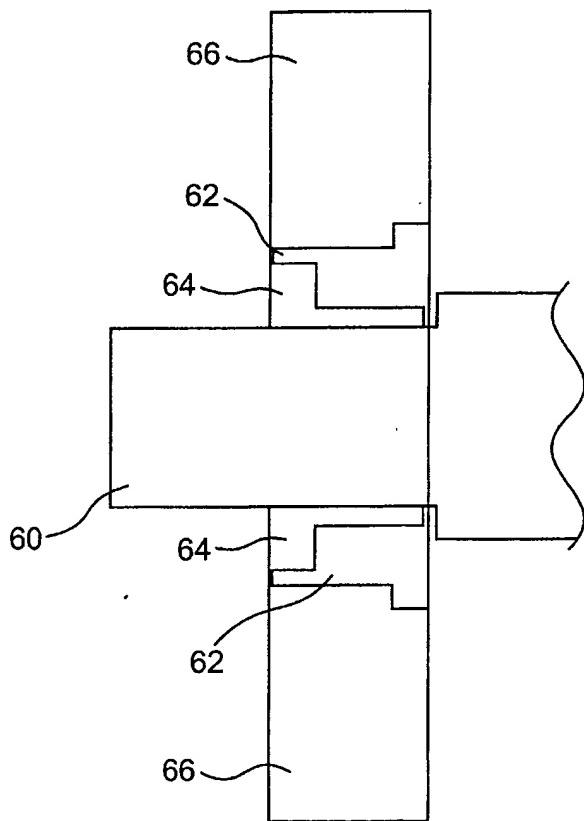


FIG. 18

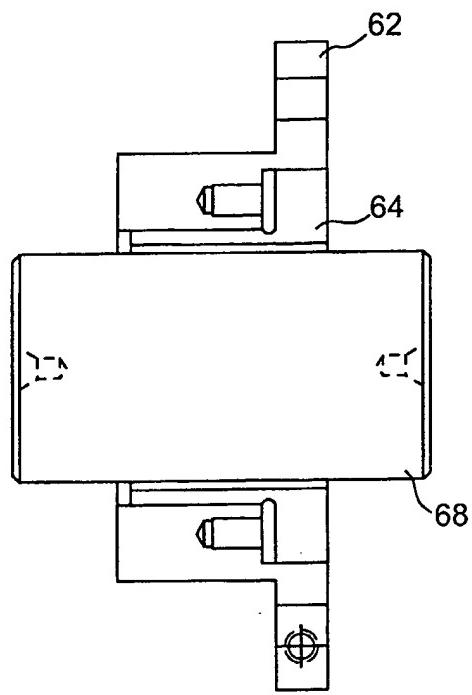


FIG. 19

PRE-HEAT-TREATED GEARS/PRECISION HUBS



FIG. 22

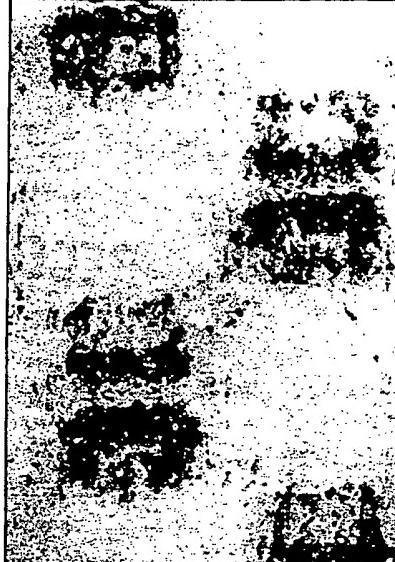


FIG. 23

STANDARD GEARS/HUBS



FIG. 20

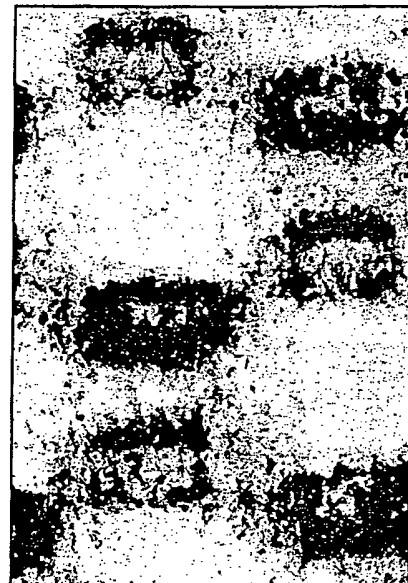


FIG. 21

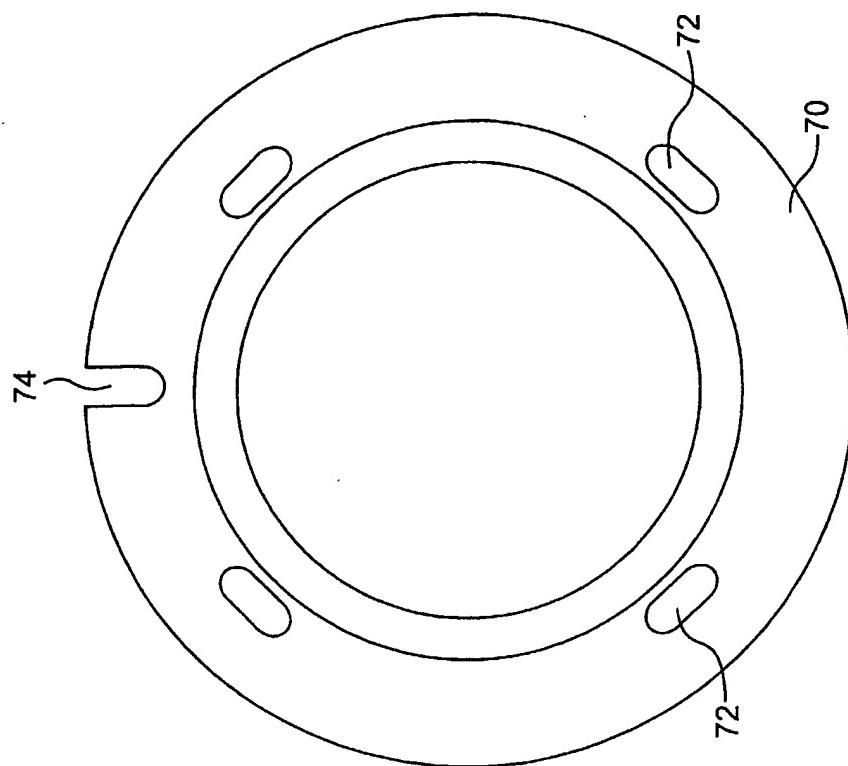


FIG. 24

